

**Techno ABS 546P**

ABS

Techno-UMG Co., Ltd.

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	<b>3.9</b>	g/10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
Molding shrinkage, parallel	<b>0.6</b>	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Strength	<b>49</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>2320</b>	MPa	ISO 178
Flexural strength	<b>74</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>16</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Rockwell hardness	<b>R 107</b>	-	ISO 2039-2
<b>Thermal properties</b>			
<b>ASTM Data</b>			
UL 94 Flame rating	<b>HB</b>	-	UL 94
<b>Other properties</b>			
Density	<b>1050</b>	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	<b>85 - 95</b>	°C	-
Pre-drying - Time	<b>2 - 5</b>	h	-
Mold temperature	<b>40 - 80</b>	°C	-
Zone 1	<b>220 - 270</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Asia Pacific

**Special Characteristics**

Heat stabilized or stable to heat