

**730Z**

ABS

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	<b>6</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

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Yield stress	<b>42</b>	MPa	ISO 527
Strain at break	<b>20</b>	%	ISO 527
Flexural modulus, 23°C	<b>2100</b>	MPa	ISO 178
Flexural strength	<b>63</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>15</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	<b>7</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	<b>R 105</b>	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>78</b>	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	<b>89</b>	°C	ISO 75-1/-2
Vicat softening temperature, B	<b>97</b>	°C	ISO 306
Burning rate, FMVSS, Thickness 1 mm	<b>80</b>	mm/min	ISO 3795 (FMVSS 302)

Other properties	Value	Unit	Test Standard
Density	<b>1050</b>	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>80 - 90</b>	°C	-
Pre-drying - Time	<b>3 - 4</b>	h	-
Processing humidity	<b>≤0.05</b>	%	-
Melt temperature	<b>220 - 240</b>	°C	-
Mold temperature	<b>50 - 80</b>	°C	-
Zone 1	<b>190 - 210</b>	°C	-
Zone 2	<b>210 - 22</b>	°C	-
Zone 3	<b>220 - 235</b>	°C	-
Nozzle temperature	<b>230 - 245</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Asia Pacific

**Special Characteristics**

U.V. stabilized or stable to weather, Heat stabilized or stable to heat