

Product Texts

Metal Plating ABS

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	23	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	23	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0055	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2200	MPa	ISO 527
Yield stress	43	MPa	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	64	MPa	ISO 178
Charpy notched impact strength, +23°C	26	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	14	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	26	kJ/m ²	ISO 180/1A
Izod notched impact strength	14	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Rockwell hardness	R 110	-	ISO 2039-2
ASTM Data			
Tensile Strength	43.2	MPa	ASTM D 638
Elongation at Break	25	%	ASTM D 638
Flexural Modulus	2256	MPa	ASTM D 790
Flexural Strength	63.8	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785
Izod Impact notched, 1/8 in	255	J/m	ASTM D 256
Izod Impact notched, 1/4 in	235	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	84	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	96	°C	ISO 75-1/-2
Vicat softening temperature, B	102	°C	ISO 306
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	3.2	mm	-
DTUL @ 264 psi	90	°C	ASTM D 648
Vicat Temperature	102	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1040	kg/m ³	ISO 1183
Density	1040	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	3 - 4	h	-
Mold temperature	40 - 80	°C	-
Zone 1	220 - 270	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific, South and Central America

Special Characteristics

Platable