

**KRALASTIC™ KU-650R-1**

ABS

Nippon A&amp;L Inc.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	<b>3</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
<b>Other Standards<sup>[S]</sup></b>			
Molding shrinkage, parallel	<b>0.5</b>	%	Producer Method

S: These properties are reported by the producer according standards that are different to our defaults.

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Yield stress	<b>55</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>2750</b>	MPa	ISO 178
Flexural strength	<b>92</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>11</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	<b>R 116</b>	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>100</b>	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	<b>74</b>	E-6/K	ISO 11359-1/-2

Other properties	Value	Unit	Test Standard
Density	<b>1060</b>	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>100 - 110</b>	°C	-
Pre-drying - Time	<b>3 - 6</b>	h	-
Melt temperature	<b>230 - 270</b>	°C	-
Mold temperature	<b>40 - 80</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Asia Pacific

**Special Characteristics**

Heat stabilized or stable to heat