

**Techno ABS F1350G10 (NC471G10)**

ABS-GX10

Techno-UMG Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	<b>21</b>	g/10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
Molding shrinkage, parallel	<b>0.4</b>	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Strength	<b>61</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>3780</b>	MPa	ISO 178
Flexural strength	<b>103</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>8</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Rockwell hardness	<b>R 109</b>	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Burning behav. at thickness h	<b>V-2</b>	class	IEC 60695-11-10
Thickness tested	<b>1.5</b>	mm	-

Other properties	Value	Unit	Test Standard
Density	<b>1180</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>2 - 5</b>	h	-
Mold temperature	<b>50 - 100</b>	°C	-
Zone 1	<b>180 - 230</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Asia Pacific

**Special Characteristics**

Flame retardant