

**PRL ABS-GP-HH**

ABS

Polymer Resources, Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	3	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	3.8	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Charpy notched impact strength, +23°C	10.5	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	13	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	6.31	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-40	°C	-
<b>ASTM Data</b>			
Tensile Modulus	2206	MPa	ASTM D 638
Tensile Strength at Yield	44.8	MPa	ASTM D 638
Tensile Strength at Break	42.1	MPa	ASTM D 638
Elongation at Yield	4.5	%	ASTM D 638
Elongation at Break	25	%	ASTM D 638
Flexural Modulus	2482	MPa	ASTM D 790
Flexural Strength	79.3	MPa	ASTM D 790
Rockwell Hardness	R112	-	ASTM D 785
Izod Impact notched, 1/8 in	187	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	53.4	J/m	ASTM D 256
Temperature	-40	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
DTUL @ 66 psi	102	°C	ASTM D 648
DTUL @ 264 psi	90.6	°C	ASTM D 648
Vicat Temperature	116	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1050	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	82.2 - 93.3	°C	-
Pre-drying - Time	2 - 5	h	-
Melt temperature	232 - 274	°C	-
Mold temperature	48.9 - 82.2	°C	-
Zone 1	193 - 210	°C	-
Zone 2	216 - 238	°C	-
Zone 3	227 - 254	°C	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets

**Special Characteristics**

Heat stabilized or stable to heat

**Applications**

General Purpose

**Regional Availability**

North America