

**Stylac 191**

ABS

Asahi Kasei

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	27	cm <sup>3</sup> /10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Melt flow index, MFI	26	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.005	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Yield stress	45	MPa	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	73	MPa	ISO 178
Charpy notched impact strength, +23°C	22	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	R 109	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	80	°C	ISO 75-1/-2
Vicat softening temperature, B	100	°C	ISO 306
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-

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

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	75 - 90	°C	-
Pre-drying - Time	3 - 4	h	-
Mold temperature	40 - 70	°C	-
Zone 1	180 - 230	°C	-
Zone 2	200 - 240	°C	-
Zone 3	220 - 260	°C	-
Nozzle temperature	210 - 250	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Applications**

General Purpose