

## TECHNICAL DATA AND PROCESS SHEET

### PERMANENTLY ANTISTATIC ABS

#### INELEC ABSAS

#### TYPICAL PROPERTIES

<b>PROPERTY</b>	<b>VALUE</b>	<b>UNIT</b>	<b>METHOD</b>
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	1.07	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.5-0.7	%	ASTM D955
<b>MECHANICAL</b>			
TENSILE STRENGTH, YLD	6,000	psi	ASTM D638
TENSILE ELONGATION, YLD	>10%	%	ASTM D638
FLEXURAL MODULUS	300,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	3.8	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	NB	ft-lb/in	ASTM D4812
<b>THERMAL</b>			
HDTUL @ 264 PSI	170	°F	ASTM D648
<b>ELECTRICAL</b>			
SURFACE RESISTIVITY	1E9-1E11	Ohms/sq	ASTM D257
<b>PROCESSING</b>			
DRYING TEMPERATURE	180	°F	
DRYING TIME	3-4	hrs	
MAX MOISTURE CONTENT	0.075	%	
MELT TEMPERATURE	460-490	°F	
MOLD TEMPERATURE	180	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0015-0.003	in	

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