

TECHNICAL DATA AND PROCESS SHEET

PERMANENTLY ANTISTATIC ABS, FLAME RETARDANT

INELEC ABSASFR

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.23	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.5-0.7	%	
MECHANICAL			
TENSILE STRENGTH, YLD	4,800	psi	ASTM D638
TENSILE ELONGATION, YLD	3-5%	%	ASTM D638
FLEXURAL MODULUS	300,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.5	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	NB	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	170	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	1E+9-1E+11	Ohms	ASTM D257
PROCESSING			
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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