

ABS PI642G

Extrusion Molding

Description

General Purpose, High Modulus

Application

Pipe Fitting

| Properties | Test Condition | Test Method | Unit | Typical Value |
|---|----------------|-------------|--------------------|---------------|
| Physical | | | | |
| Specific Gravity | | ASTM D792 | - | 1.04 |
| Molding Shrinkage (Flow), 3.2mm | | ASTM D955 | % | 0.4~0.7 |
| Melt Flow Rate | 220°C/10kg | ASTM D1238 | g/10min | 8 |
| Mechanical | | | | |
| Tensile Strength, 3.2mm | | ASTM D638 | | |
| @ Yield | 50mm/min | | kg/cm ² | 570 |
| Tensile Elongation, 3.2mm | | ASTM D638 | | |
| @ Yield | 50mm/min | | % | >5 |
| @ Break | 50mm/min | | % | 30 |
| Tensile Modulus, 3.2mm | 1mm/min | ASTM D638 | kg/cm ² | |
| Flexural Strength, 3.2mm | 15mm/min | ASTM D790 | kg/cm ² | 900 |
| Flexural Modulus, 3.2mm | 15mm/min | ASTM D790 | kg/cm ² | 28,000 |
| IZOD Impact Strength, 6.4mm (Notched) | | ASTM D256 | | |
| | 23 °C | | kg·cm/cm | 24 |
| | -30 °C | | kg·cm/cm | |
| IZOD Impact Strength, 3.2mm (Notched) | | ASTM D256 | | |
| | 23 °C | | kg·cm/cm | 27 |
| | -30 °C | | kg·cm/cm | |
| Rockwell Hardness | R-Scale | ASTM D785 | - | 110 |
| Thermal | | | | |
| Heat Deflection Temperature, 6.4mm (Unannealed) | | ASTM D648 | | |
| | 18.6kg | | °C | 86 |
| | 4.6kg | | °C | 92 |
| Vicat Softening Temperature | | ASTM D1525 | | |
| | 5kg, 50 °C/h | | °C | 94 |
| Flammability | | UL94 | | |
| Relative Temperature Index | | UL 746B | | |
| Electrical | | | °C | |
| Mechanical with Impact | | | °C | |
| Mechanical without Impact | | | °C | |

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 www.kedisujiao.com

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Electrical

| | | | |
|--|------------|-----------|--------|
| Comparative Tracking Index(CTI) | Solution A | IEC 60112 | Volts |
| Surface Resistivity | | IEC 60093 | Ohm |
| Volume Resistivity | 23℃ | ASTM D257 | Ohm·m |
| Arc Resistance | 23℃ | ASTM D495 | Ohm·cm |
| Dielectric Strength, 1mm | 23℃ | ASTM D149 | kV/mm |
| Dielectric Constant (10 ⁶ Hz) | 23℃ | ASTM D150 | sec |

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Processing Guide (Extrusion Molding)

| Processing Parameters | | Unit | Value |
|--------------------------|--------|------|-----------|
| Drying Temperature | | ℃ | 70 ~ 80 |
| Drying Time | | hrs | 3 ~ 4 |
| Minimum Moisture Content | | % | 0.01 |
| Melt Temperature | | ℃ | 200 ~ 250 |
| Barrel Temperature | Zone 1 | ℃ | 180 ~ 210 |
| | Zone 2 | ℃ | 190 ~ 230 |
| | Zone 3 | ℃ | 200 ~ 250 |
| | Zone 4 | ℃ | 200 ~ 250 |
| Adapter Temperature | | ℃ | 200 ~ 250 |
| Die Temperature | | ℃ | 200 ~ 250 |
| Roll Stack Temperature | Top | ℃ | 70 ~ 100 |
| | Middle | ℃ | 70 ~ 90 |
| | Bottom | ℃ | 60 ~ 90 |

Note) Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.

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