

ABS XR409E

Injection Molding

Description

Heat Resistance

Application

Automotives Interior Housing
(Switch Panel Housing etc)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.07
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.7
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	6
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	480
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	>5
@ Break	50mm/min		%	20
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm ²	800
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm ²	26,000
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23℃		kg-cm/cm	14
	-30℃		kg-cm/cm	7
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg-cm/cm	15
	-30℃		kg-cm/cm	7
Rockwell Hardness	R-Scale	ASTM D785	-	111
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	104
	4.6kg		℃	112
Vicat Softening Temperature		ASTM D1525		
	5kg, 50℃/h		℃	110
Flammability		UL94		HB
Relative Temperature Index		UL 746B		
Electrical			℃	60
Mechanical with Impact			℃	60
Mechanical without Impact			℃	60

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℃, 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

备注：以上原料物性数据由厂家发布, 我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

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Electrical

Property	Condition	Standard	Unit	Value
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	0
Surface Resistivity		IEC 60093	Ohm	-
Volume Resistivity	23 °C	ASTM D257	Ohm·m	1.5E+01
Arc Resistance	23 °C	ASTM D495	Ohm·cm	6
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	33
Dielectric Constant (10 ⁶ Hz)	23 °C	ASTM D150	sec	-

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	80 ~ 90	
Drying Time	hrs	3 ~ 4	
Minimum Moisture Content	%	0.01	
Melt Temperature	°C	230 ~ 250	
Cylinder Temperature	Rear	°C	180 ~ 220
	Middle	°C	220 ~ 240
	Front	°C	230 ~ 250
Nozzle Temperature	°C	240 ~ 250	
Mold Temperature	°C	60 ~ 80	
Back Pressure	kg/cm ²	20 ~ 40	
Screw Speed	rpm	50 ~ 100	

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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