Technical Data Sheet

ABS4124

Description

A post-consumer recycled acrylonitrile-butadiene-styrene copolymer for general use. Available in standard black (reference 90/04) and dark black (reference 90/05)

Material Properties

	Value	Unit	Test Method
Physical			
Density	1.05	g/cm^3	ISO 1183
Rheological			
Melt Flow Rate (230°C / 3.8 kg)	6	g/10 min	ISO 1133
Melt Flow Rate (220°C / 10.0 kg)	22	g/10 min	ISO 1133
Mechanical			
Tensile Stress at Yield (23°C)	40	MPa	ISO 527-2/50
Flexural Modulus (23°C)	2100	MPa	ISO 178
Impact			
Notched Izod Impact Strength (23°C)	10	kJ/m^2	ISO 180/1A
Thermal			
HDT A (1.8 MPa), unannealed	80	^oC	ISO 75-1 A
Vicat softening temperature VST/A/50	104	^oC	ISO 306
Vicat softening temperature VST/B/50	95	^oC	ISO 306

Note:

The data above is provided in good faith and represents typical properties based on our current knowledge and experience. Product properties may be changed without notice. These properties are provided as a guide and should not be construed as binding specification limits or minimum values. This document does not create any liability, warranty or guarantee of product performance. It is the buyer's responsibility to determine the suitability of MBA Polymers products for the intended application. We DO NOT recommend our materials for toys or for applications that involve food contact or human oral contact or for medical applications.

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Processing Information

	Value	Unit
Preprocessing		
Drying Temperature	80	°C
Drying Time	2-4	hr
Moisture Content	<0.05-0.10	%
Injection Molding		
Melt Temperature Range	210-230	°C
Recommended Melt Temperature	215	°C
Mold Temperature Range	40-60	°C
Recommended Mold Temperature	50	°C
Extrusion		
Melt Temperature Range	200-220	°C
Recommended Melt Temperature	210	°C

Note:

The processing parameters listed above are general guidelines based on our current knowledge and experience. The suitability of the data for a specific processing method can only be ensured with investigations and tests by the end user.