

TPI Porene® ABS-GA850 High Impact ABS Resin

Category : Polymer , Thermoplastic , ABS Polymer , Acrylonitrile Butadiene Styrene (ABS), Impact Grade, Molded

Material Notes:

Information provided by US distributor Polymer Technology and Services, LLC (PTS).

Order this product through the following link:

http://www.lookpolymers.com/polymer_TPI-Porene-ABS-GA850-High-Impact-ABS-Resin.php

Physical Properties	Metric	English	Comments
Density	1.05 g/cc	0.0379 lb/in ³	ASTM D792
Melt Flow	20 g/10 min	20 g/10 min	
	@Load 10.0 kg, Temperature 220 °C	@Load 22.0 lb, Temperature 428 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	118	118	ASTM D785
Tensile Strength, Yield	51.7 MPa	7500 psi	
	@Thickness 3.17 mm	@Thickness 0.125 in	
Flexural Yield Strength	70.3 MPa	10200 psi	
	@Thickness 3.17 mm	@Thickness 0.125 in	
Flexural Modulus	2.34 GPa	339 ksi	
	@Thickness 3.17 mm	@Thickness 0.125 in	
Izod Impact, Notched	2.67 J/cm	5.00 ft-lb/in	
	@Thickness 6.35 mm	@Thickness 0.250 in	
	2.99 J/cm	5.60 ft-lb/in	
	@Thickness 3.17 mm	@Thickness 0.125 in	

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	96.0 °C	205 °F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	87.0 °C	189 °F	ASTM D648
Flammability, UL94	HB	HB	
	@Thickness 1.59 mm	@Thickness 0.0625 in	
	HB	HB	

Thermal Properties	@Thickness 3.17 mm Metric	@Thickness 0.125 in English	Comments
Processing Properties	Metric	English	Comments
Rear Barrel Temperature	193 °C	380 °F	
Middle Barrel Temperature	216 °C	420 °F	
Front Barrel Temperature	232 °C	450 °F	
Melt Temperature	218 - 260 °C	425 - 500 °F	Nozzle temp not greater than stock
Mold Temperature	48.9 - 65.6 °C	120 - 150 °F	
Drying Temperature	87.8 - 93.3 °C	190 - 200 °F	
Dry Time	2 - 24 hour	2 - 24 hour	
Injection Pressure	68.9 - 82.7 MPa	10000 - 12000 psi	
Back Pressure	0.689 MPa	100 psi	
Screw Speed	50 - 60 rpm	50 - 60 rpm	

Descriptive Properties	Value	Comments
Injection Fill Speed	Slow to Moderate	

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