

TECHNICAL DATA SHEET

Shuman Compound:

ABS 710 Utility black, 720 Black, 730 White, 780 Grey

Offers this combination of properties:

Good impact strength, Easy processability, Good chemical resistance

TYPICAL PROPERTIES

MECHANICAL PROPERTIES	VALUE	<u>UNITS</u>	TEST METHODS				
Izod Impact Strength (Notched, 1/8" Thick Specimen)	4.0 (+/- 0.5)	FT-LBS/IN	ASTM D-256				
Rockwell Hardness	102	R	ASTM D-785				
THERMAL PROPERTIES							
Heat Deflection Temperature @ 264 PSI	169	deg. F	ASTM D-648				
OTHER PROPERTIES							
Specific Gravity	1.04		ASTM D-792				
Melt Flow Rate	4 (+/-2)	GM/10 MIN.	ASTM D-1238				

SUGGESTED PROCESSING CONDITIONS

DRYING CONDITIONS:		TEMPERATURE (deg. F)		TIME (HOURS)		
		MIN.	MAX.	MIN.	MAX.	
Dehumidifyir	ng Dryer	190	200	2	24	
Tray Dryer	NOTE: Depth of granules in tray dryer should not exceed 1½ in. (38.1 mm)	170	200	4	24	

TEMPERATURE CONDITIONS:

INJECTION: 400 - 440F EXTRUSION: 350 - 420F

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