

# ER232

Injection Molding Grade

## Description

- Medium Heat Resistant Metal Plating ABS

## Applications

- Automobile Radiator Grille, Molding

Properties	Method	Unit	ER232
<b>Physical</b>			
Specific Gravity , 23°C	ISO 1183		1.04
Mold Shrinkage , 23°C, 3.2mm , 23°C	ISO 294-4	%	0.4 ~ 0.7
Melt Volume Rate , 220°C, 10kg	ISO 1133	cm <sup>3</sup> /10min	26
<b>Mechanical</b>			
Tensile Strength at Yield , 23°C, 50mm/min, 4mm	ISO 527	MPa	43
Tensile Modulus , 23°C, 50mm/min, 4mm	ISO 527	MPa	2200
Flexural Strength , 23°C, 2mm/min, 4mm	ISO 178	MPa	72
Flexural Modulus , 23°C, 2mm/min, 4mm	ISO 178	MPa	2500
Izod Impact Strength , Notched, 4mm, 23°C	ISO 180/1A	kJ/m <sup>2</sup>	24
Charpy Impact Strength , 4mm, 23°C	ISO 179/1eA	kJ/m <sup>2</sup>	24
Rockwell Hardness , R-Scale	ISO 2039		109
<b>Thermal</b>			
HDT , Flatwise, 1.8MPa, 4mm, Unannealed	ISO 75	°C	84
VICAT , 50N, 50°C/h	ISO 306	°C	101

## Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.

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

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

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## Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 95
Drying Time	hrs	3 ~ 4
Moisture Content	%	0.05 ~
Melt Temperature	°C	230 ~ 250
Nozzle Temperature	°C	230 ~ 250
Mold Temperature	°C	40 ~ 80
Back Pressure, Hydraulic Type	kg/cm <sup>2</sup>	7 ~ 15
Screw Speed	rpm	~ 60

## Note

Back Pressure & Measuring 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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