

# ABS MP211A

Injection Molding Grade

## Description

High Flow Metal Plating ABS

## Application

Decorative Part(Home Appliance Door Handle)

구분	측정조건	규격	단위	수치
<b>물리적 특성</b>				
비중		ASTM D792	-	1.04
수축율, 3.2mm		ASTM D955	%	0.4~0.7
유동지수	220℃/10kg	ASTM D1238	g/10min	28
<b>기계적 특성</b>				
인장강도, 3.2mm		ASTM D638		
@ 항복점	50mm/min		kg/cm <sup>2</sup>	450
굴곡강도, 3.2mm	15mm/min	ASTM D790	kg/cm <sup>2</sup>	760
굴곡탄성율, 3.2mm	15mm/min	ASTM D790	kg/cm <sup>2</sup>	27,000
아이조드 충격강도, 6.4mm (Notched)	23℃	ASTM D256	kg-cm/cm	23
아이조드 충격강도, 3.2mm (Notched)	23℃	ASTM D256	kg-cm/cm	31
Rockwell 경도	R-Scale	ASTM D785	-	110
<b>열적 특성</b>				
열변형온도, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	℃	89
Vicat 연화점	5kg, 50℃/h	ASTM D1525	℃	97
난연성		UL94		HB
Relative Temperature Index		UL 746B		
Electrical			℃	60
Mechanical with Impact			℃	60
Mechanical without Impact			℃	60
<b>광학특성</b>				
광택도	45°	ASTM D2457	-	

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 molded specimens and after 48 hours storage at 23℃, 50% relative humidity.

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### 사출성형 가이드

성형 조건		단위	Value
건조온도		℃	70 ~ 80
건조시간		hrs	3 ~ 4
최소 수분율		%	0.01
녹는점		℃	220 ~ 240
실린더 온도	Rear	℃	200 ~ 220
	Middle	℃	210 ~ 230
	Front	℃	220 ~ 240
노즐 온도		℃	220 ~ 240
금형온도		℃	50 ~ 70
배압		bar	10 ~ 30
스크류 속도		rpm	under 60 (Low Speed)

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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