**ABS 448T**

Molding Grade ABS and w/ UV

**Typical Material Properties**

|  |  |  |
| --- | --- | --- |
| Physical Properties | Nominal Values | ASTM Test |
| Specific Gravity | 1.04 | D792 |
| Melt Flow (230 °C/3.8 kg) | 5.0 g/10 min | D1238 |

|  |  |  |
| --- | --- | --- |
| Mechanical Properties |  |  |
| Tensile Modulus | 350,000 psi | D638 |
| Tensile Strength at Yield | 6,500 psi | D638 |
| Flexural Modulus | 350,000 psi | D790 |
| Flexural Strength at Yield | 10,500 psi | D790 |

|  |  |  |
| --- | --- | --- |
| Impact |  |  |
| Notched Izod Impact (73 °F, 0.125 in) | 5.0 ft-lb/in | D256 |

|  |  |  |
| --- | --- | --- |
| Thermal |  |  |
| DTUL @ 264 psi-unannealed (0.125 in) | 183 °F | D648 |

|  |  |  |
| --- | --- | --- |
| Mold Shrinkage |  |  |
| Linear Flow | .004 - .008 in/in | D955 |
| UL Rating | HB (1.5 mm) | UL 94 |

**Recommended Processing Guidelines**

|  |  |
| --- | --- |
|  | Nominal Values |
| Drying Time and Temperature | 2.0 - 4.0 hrs. at 180 - 200 ºF |
| Suggested Max Moisture | 0.15% |
| Rear Temperature | 370 – 425 ºF |
| Middle Temperature | 400 – 450 ºF |
| Front Temperature | 425 – 475 ºF |
| Nozzle Temperature | 425 – 525 ºF |
| Processing (melt) Temperature | 425 - 525 °F |
| Mold Temperature | 120 - 170 °F |
| Back Pressure | 25 - 100 psi |
| Screw Speed | 25 - 75 rpm |

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.