**Inj-02C ABS**

Clear general-purpose injection molding grade

**Typical Material Properties**

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| General |  |  |
| Material Status | Commercial: Active |  |
| Availability | North America |  |
| Features | General Purpose |  |
| Uses | Appliances | Consumer Applications |
|  | Housings | Toys |
| Processing Method | Injection Molding |  |

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| Physical Properties | Nominal Values | Test Method |
| Specific Gravity | 1.10 | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg) | 20 g/10 min |  |
| Molding Shrinkage - Flow | 3.0E-3 to 7.0E-3 in/in | ASTM D955 |

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| Hardness |  |  |
| Rockwell Hardness (R-Scale) | 108 | ASTM D785 |

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| Mechanical Properties |  |  |
| Tensile Strength (Yield, 0.125 in) | 6400 psi | ASTM D638 |
| Tensile Elongation (Break, 0.125 in) | > 50 % | ASTM D638 |
| Flexural Modulus (0.125 in) | 310000 psi | ASTM D790 |
| Flexural Strength (Yield, 0.125 in) | 9700 psi | ASTM D790 |

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| Impact |  |  |
| Notched Izod Impact |  | ASTM D256 |
| 0.125 in | 2.2 ft·lb/in |  |
| 0.250 in | 1.8 ft·lb/in |  |

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| Thermal |  |  |
| Deflection Temperature Under Load (264 psi, Unannealed, 0.250 in) | 176 °F | ASTM D648 |
| Vicat Softening Temperature | 199 °F | ISO 306 |

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| Flammability |  |  |
| Flame Rating |  | UL 94 |
| 0.0591 in | HB |  |
| 0.118 in | HB |  |

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| Optical |  |  |
| Transmittance (118 mil) | 90.0 % |  |

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| Injection | Nominal Value Unit |
| Drying Temperature | 167 to 176 °F |
| Drying Time | 2.0 to 4.0 hr |
| Processing (Melt) Temp | 374 to 446 °F |
| Mold Temperature | 104 to 176 °F |
| Injection Pressure | 9940 to 15600 psi |
| Back Pressure | 142 to 284 psi |
| Screw Speed | 60 to 90 rpm |

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| Notes |
| 1These links provide you with access to supplier literature. We work hard to keep them up to date; however you may find the most current literature from the supplier. |