

# ABS HI121H

Injection Molding Grade

## Description

Well balanced mechanical properties

## Application

Electric/electronic products, miscellaneous goods

Properties	Test Method	Test Condition	Unit	Typical Value
<b>Physical</b>		ASTM		
Melt Flow Rate	D1238	220°C/10kg	g/10min	22
Specific Gravity	D792	23°C		1.03
Molding Shrinkage	D955		%	0.4-0.7
<b>Mechanical</b>				
Tensile Strength 3.2mm	D638	50mm/min	kg/cm <sup>2</sup>	500
Tensile Elongation 3.2mm	D638	50mm/min	%	25
Flexural Strength 6.4mm	D790	15mm/min	kg/cm <sup>2</sup>	800
Flexural Modulus 6.4mm	D790	15mm/min	kg/cm <sup>2</sup>	26000
IZOD Impact Strength 6.4mm	D256	23°C	kg.cm/cm	23
		-30°C		-
Rockwell Hardness	D785	R-Scale		109
<b>Thermal</b>				
Heat Deflection Temperature, 6.4mm(Unannealed)	D648	18.6KG	°C	87
Vicat Softening Temperature	D1525	1kg	°C	95
Flammability	UL94	1.5mm	class	HB

**Note:**

The above values are only the representatives of the natural color specimen, not for guarantee.

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## Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	℃	75 ~ 85	
Drying Time	hrs	2 ~ 4	
Cylinder Temperature	Rear	℃	180 ~ 200
	Middle	℃	190 ~ 210
	Front	℃	200 ~ 220
Nozzle Temperature	℃	200 ~ 230	
Melt Temperature	℃	210 ~ 240	
Mold Temperature	℃	40 ~ 70	
Injection pressure	injection pressure	MPa	60 ~ 100
	holding pressure	MPa	70 ~ 90
	Back pressure	MPa	0.5 ~ 1
Screw rotate speed	%	30 ~ 60	

Note: These data only a general information to the best of our knowledge. It can not be guaranteed due to variance of materials, conditions and equipments.

