

TECHNICAL DATA SHEET

Shuman Compound:

ABS 710H Utility black, 720H Black, 730H White, 780H Grey

Offers this combination of properties:

Good impact strength, Easy processability, Good chemical resistance

TYPICAL PROPERTIES

<u>MECHANICAL PROPERTIES</u>	<u>VALUE</u>	<u>UNITS</u>	<u>TEST METHODS</u>
Izod Impact Strength (Notched, 1/8" Thick Specimen)	4.0 (+/- 0.5)	FT-LBS/IN	ASTM D-256
Rockwell Hardness	102	R	ASTM D-785
 <u>THERMAL PROPERTIES</u>			
Heat Deflection Temperature @ 264 PSI	169	deg. F	ASTM D-648
 <u>OTHER PROPERTIES</u>			
Specific Gravity	1.04		ASTM D-792
Melt Flow Rate	4 (+/-2)	GM/10 MIN.	ASTM D-1238

SUGGESTED PROCESSING CONDITIONS

<u>DRYING CONDITIONS:</u>	<u>TEMPERATURE (deg. F)</u>		<u>TIME (HOURS)</u>	
	<u>MIN.</u>	<u>MAX.</u>	<u>MIN.</u>	<u>MAX.</u>
Dehumidifying Dryer	190	200	2	24
Tray Dryer NOTE: Depth of granules in tray dryer should not exceed 1½ in. (38.1 mm)	170	200	4	24

TEMPERATURE CONDITIONS:

INJECTION: 400 - 440F
EXTRUSION: 350 - 420F

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