

Dayson Polymers, LLC
ABS PORENE® GA300
Acrylonitrile Butadiene Styrene
High Flow Grade, High Gloss

Property	Test Condition	Nominal Values (English)	Test Method
Physical			
Melt Flow Rate	220°C/10.0 kg – G	30 g/10	ASTM D1238
Mold Shrink, Linear-Flow		0.0040 to 0.0060 in/in	ASTM D955
Mechanical			
Tensile Strength	73°F	6,830 psi	ASTM D638
Flexural Modulus	73°F	327,137 psi	ASTM D790
Flexural Strength	73°F	9,530 psi	ASTM D790
Impact			
Notched Izod Impact	73°F, 0.250 in	4.04 ft-lb/in	ASTM D256
Hardness			
Rockwell Hardness	R-Scale, 0.250 in	112	ASTM D785
Thermal			
DTUL @ 264 psi - Unannealed	0.250 in	187 °F	ASTM D648
DTUL @ 66 psi - Unannealed	0.250 in	201 °F	ASTM D648
Ignition Characteristics			
Flame Rating – UL (0.126in)		HB	UL-94
PROCESSING INFORMATION			
Injection Molding Parameters		Nominal Values (English)	
Drying Temperature		176 to 185 °F	
Drying Time		2.0 to 3.0 hr	
Processing (Melt) Temp		356 to 482 °F	
Mold Temperature		104 to 140 °F	

APPLICATION: INJECTION MOLDING
APPLIANCES, BUSINESS EQUIPMENT, ELECTRICAL PARTS, AUTOMOTIVE APPLICATIONS,
HOUSEHOLD GOODS, TOYS

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