

**Dayson Polymers, LLC**  
**ABS PORENE® GA850 Property Data Sheet**  
**Acrylonitrile Butadiene Styrene**  
**High Impact/High Gloss**

Property	Test Condition	Nominal Values (English)	Test Method
<b>Physical</b>			
Melt Flow Rate	220°C/10.0 kg – G	20 g/10	ASTM D1238
<b>Mechanical</b>			
Tensile Strength	73°F	7,540 psi	ASTM D638
Flexural Modulus	73°F	341,360 psi	ASTM D790
Flexural Strength	73°F	10,200 psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact	73°F, 0.250 in	4.96	ASTM D256
<b>Hardness</b>			
Rockwell Hardness	R-Scale, 0.250 in	118	ASTM D785
<b>Thermal</b>			
DTUL @ 264 psi - Unannealed	0.250 in	189 °F	ASTM D648
DTUL @ 66 psi - Unannealed	0.250 in	205 °F	ASTM D648
<b>Ignition Characteristics</b>			
Flame Rating – UL (0.25in)		HB	UL-94
<b>PROCESSING INFORMATION</b>			
<b>Injection Molding Parameters</b>		<b>Nominal Values (English)</b>	
Drying Temperature		176 to 185 °F	
Drying Time		2.0 to 3.0 hr	
Processing (Melt) Temp		386 to 482 °F	
Mold Temperature		104 to 140°F	

**APPLICATION: INJECTION MOLDING**

**APPLIANCES, AUTOMOTIVE APPLICATIONS, HOUSEHOLD GOODS, TOYS**

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