

Dayson Polymers, LLC
ABS PORENE® KU650 Property Data Sheet
Acrylonitrile Butadiene Styrene
Heat Resistant

Property	Test Condition	Nominal Values (English)	Test Method
Physical			
Melt Flow Rate	220°C/10.0 kg – G	1.8 g/10min	ASTM D1238
Mold Shrink, Linear-Flow		0.0040 to 0.0060 in/in	ASTM D955
Mechanical			
Tensile Strength	73°F	6,400 psi	ASTM D638
Flexural Modulus	73°F	298,690 psi	ASTM D790
Flexural Strength	73°F	9,250 psi	ASTM D790
Impact			
Notched Izod Impact	73°F, 0.250 in	2.57 ft-lb/in	ASTM D256
Hardness			
Rockwell Hardness	R-Scale, 0.250 in	110	ASTM D785
Thermal			
DTUL @ 264 psi - Unannealed	0.250 in	235 °F	ASTM D648
DTUL @ 66 psi - Unannealed	0.250 in	252 °F	ASTM D648
Ignition Characteristics			
Flame Rating – UL (0.126in)		HB	UL-94
PROCESSING INFORMATION			
Injection Molding Parameters		Nominal Values (English)	
Drying Temperature		194 to 212 °F	
Drying Time		2.0 to 3.0 hr	
Processing (Melt) Temp		428 to 500 °F	
Mold Temperature		104 to 176°F	

APPLICATION: INJECTION MOLDING
HANDLES, ELECTRICAL PARTS, AUTOMOTIVE APPLICATIONS, HOUSEHOLD GOODS, TOYS
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