

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

Property	Test Condition	Nominal Values (English)	Test Method
<b>Physical</b>			
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
<b>Mechanical</b>			
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
<b>Impact</b>			
Notched Izod Impact	73°F, 0.250 in	2.57 ft-lb/in	ASTM D256
<b>Hardness</b>			
Rockwell Hardness	R-Scale, 0.250 in	110	ASTM D785
<b>Thermal</b>			
DTUL @ 264 psi - Unannealed	0.250 in	235 °F	ASTM D648
DTUL @ 66 psi - Unannealed	0.250 in	252 °F	ASTM D648
<b>Ignition Characteristics</b>			
Flame Rating – UL (0.126in)		HB	UL-94
<b>PROCESSING INFORMATION</b>			
<b>Injection Molding Parameters</b>		<b>Nominal Values (English)</b>	
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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