Dayson Polymers, LLC

ABS PORENE® SP100 Property Data Sheet

Acrylonitrile Butadiene Styrene

Super High Impact/High Gloss

Property	Test Condition	Nominal Values (English)	Test Method
Physical			
Melt Flow Rate	220°C/10.0 kg – G	18 g/10 min	ASTM D1238
Mold Shrink, Linear-Flow		0.0040 to 0.0060 in/in	ASTM D955
Mechanical			
Tensile Strength	73°F	6400 psi	ASTM D638
Flexural Modulus	73°F	312914 psi	ASTM D790
Flexural Strength	73°F	9250 psi	ASTM D790
Impact			
Notched Izod Impact	73°F, 0.250 in	6.24 ft-lb/in	ASTM D256
Hardness			
Rockwell Hardness	R-Scale, 0.250 in	110	ASTM D785
Thermal			
DTUL @ 264 psi - Unannealed	0.250 in	183 °F	ASTM D648
DTUL @ 66 psi - Unannealed	0.250 in	194 °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**
AUTOMOTIVE APPLICATIONS, SAFETY HELMETS, ELECTRICAL PARTS, HOUSEHOLD GOODS, TOYS

Remark: The values presented on the above are typical laboratory averages. All data generated is based on natural material.