

## Technical Data Sheet

### *Polyman* ABS K1836 BLK70085



Acrylonitrile Butadiene Styrene

#### Product Description

Easy flow medium impact ABS grade

**Processing Method** Injection Molding

**Attribute** Good Flow; Medium Impact Resistance

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Melt Volume Flow Rate, (220 °C/10.0 kg)	35	cm <sup>3</sup> /10 min	ISO 1133
Density, (Method A)	1.10	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	42.0	MPa	ISO 527-2
Tensile Strain at Yield, (Type 1A, 50 mm/min)	2.2	%	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	2500	MPa	ISO 527-1
<b>Impact</b>			
Charpy Impact Strength - Notched, (23 °C, Type 1, Edgewise, Notch A)	15	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched, (23 °C, Type 1, Edgewise)	No Break		ISO 179
<b>Thermal</b>			
Vicat Softening Temperature, (B (50N), 50 °C/h)	95.0	°C	ISO 306
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	77.0	°C	ISO 75-2/A
<b>Flammable</b>			
Burning Rate			
(2.00 mm)	<100	mm/min	FMVSS 302
(2.00 mm)	<100	mm/min	ISO 3795
<b>Injection Parameters</b>			
Drying Time	2.0 to 4.0	hr	
Drying Temperature	80	°C	
Processing (Melt) Temp	230 to 250	°C	
Mold Temperature	30 to 80	°C	