




Material Datasheet 4

Trade Name : ABS Black	
Material : Acrylonitrile Butadiene Styrene (ABS)	
Grade : ABS BK 08	

Properties	Test Method	Test Condition	Unit	Typical Value
Physical				
Specific Gravity	ASTM D792	23°C/23°C	g/cm ³	1.06
Mold Shrinkage	ASTM D995	3.2mm	%	0.4
Rheological				
Melt Flow Index	ASTM D1238	220°C - 10kg	g/10min	18 - 25
Mechanical				
Tensile Strength	ASTM D638	23°C	kg/cm ²	250 - 350
Rockwell Hardness	ASTM D785	23°C	R-Scale	R-110
Flexural Strength	ASTM D790	23°C	kg/cm ²	550 - 650
Flexural Modulus	ASTM D790	23°C	kg/cm ²	16000 - 20000
Izod Impact	ASTM D256	V-notched, 1/8"	kg.cm/cm	8 - 10
Thermal				
Heat Distortion Temp.	ASTM D648	Unannealed	°C	84 - 85
Flammability				
Flammability	UL 94			HB

Recommended Injection Molding Parameters

Barrel Temperature	Value	Mold Temperature	Value
Zone 1	180 - 200°C	Fixed Half	40 - 60°C
Zone 2	200 - 220°C	Moving Half	40 - 60°C
Zone 3	200 - 220°C	Drying Hour	3 - 4
Zone 4	210 - 230°C	Drying Temperature	80 - 90°C
Nozzle	190 - 210°C	Melt Temperature	190 - 240°C

The data are intended as a general guide only and do not necessarily represent results that may be obtained elsewhere. For further information, please contact or fax to Zinco Colours Technical Services Department.



Raw Materials



Finished Products

YAMAHA - Motorcycle Parts

