



Nexus ABS22

Low Melt ABS

Typical Properties

Physical	Nominal Values (English)	Test
Specific Gravity	1.05	ASTM D792
Melt Flow (230 °C/3.8 kg.)	2.0 g/10 min	ASTM D1238
Mechanical		
Tensile Modulus	280,000 psi	ASTM D638
Tensile Strength @ Yield	5,000 psi	ASTM D638
Flexural Modulus	290,000 psi	ASTM D790
Flexural Strength @ Yield	6,000 psi	ASTM D790
Impact		
Notched Izod Impact (73°F, 0.125 in.)	2.0 ft-lb/in	ASTM D256
Mold Shrinkage		
Linear Flow	.004 - .008 in/in	ASTM D955

Recommended Processing Guidelines

	Nominal Values (English)	Metric
Drying Temperature	180 to 200 °F	
Drying Time	2.0 to 4.0 hr	
Suggested Max Moisture	0.15 %	
Rear Temperature	370 to 425 °F	
Middle Temperature	400 to 450 °F	
Front Temperature	425 to 475 °F	
Nozzle Temperature	425 to 525 °F	
Processing (Melt) Temp	425 to 525 °F	
Mold Temperature	120 to 170 °F	
Back Pressure	25 to 100 psi	
Screw Speed	25 to 75 rpm	

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.

Tips on resolving common surface issues:

- (1) Check the dryer mechanical functions and temperature settings as well as the time in the dryer. Shooting an air-shot from the barrel helps to indicate poor drying conditions. If the air-shot bubbles and foams, then poor drying is suspect.
- (2) Excessive heat via: temperature settings too high; too fast of an inject speed; small/tight gating or other

shear induced heating, are common items to review.

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