Nexus ABSFR1 - Molding Grade ABSFR

Nexus ABSFR1UV - Molding Grade ABSFR with UV

Typical Properties

Physical	Nominal Values (English)	Test
Specific Gravity	1.22	ASTM D792
Melt Flow (230 °C/3.8 kg.)	6.0 g/10 min	ASTM D1238
Mechanical		
Tensile Modulus	315,000 psi	ASTM D638
Tensile Strength @ Yield	5,300 psi	ASTM D638
Flexural Modulus	325,000 psi	ASTM D790
Flexural Strength @ Yield	9,300 psi	ASTM D790
Impact		
Notched Izod Impact (73ºF, 0.125 in.)	3.0 ft lb/in	ASTM D256

Thermal

DTUL @ 264 psi-unannealed (.125 in.)	168 °F	ASTM D648

Mold Shrinkage

Linear Flow	.005 - .008 in/in	ASTM D955
UL Rating	V0 (.062")	UL 94

<u>Recommended Processing Guidelines</u>

	Nominal Values (English)	Metric
Drying Temperature	170 to 190 °F	
Drying Time	2.0 4.0 hr	
Suggested Max Moisture	0.15 %	
Rear Temperature	300 to 360 °F	
Middle Temperature	350 to 400 °F	
Front Temperature	375 to 450 °F	
Nozzle Temperature	375 to 450 °F	
Processing (Melt) Temp	375 to 450 °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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