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## NEXUS ABSVX5009 BKS40001

*Utility Grade - Injection Molding ABS*

Uncontrolled gloss and surface, black only

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### *Typical Properties*

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Physical	Nominal Values (English)	Test
Specific Gravity	1.05	ASTM D792
Melt Flow (230 °C/3.8 kg.) (73°F, 0.125 in.)	3 g/10 min	ASTM D1238
<b>Mechanical</b>		
Tensile Modulus	300,000 psi	ASTM D638
Tensile Strength @ Yield	5,500 psi	ASTM D638
Flexural Modulus	300,000 psi	ASTM D790
Flexural Strength @ Yield	7,500 psi	ASTM D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in.)	3 ft-lb/in	ASTM D256

## Mold Shrinkage

Linear Flow 0.004-0.008 in/in ASTM D955

## Recommended Processing Guidelines

	Nominal Values (English)
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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