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**Technical Data Sheet**

**DYN-ABS Black**

**General Purpose, Molding Grade ABS**

Typical Compound Properties	Value / Measure		Test Methods
<b>Physical Properties</b>			
	English Units	Metric Units	
Density	1.06 g/cm <sup>3</sup>	1.06 g/cm <sup>3</sup>	ASTM D-792
Melt Flow Rate @ 230° / 3.8kg	5.5 g/10 min		ASTM D-792
<b>Mechanical Properties</b>			
Izod Impact - Notched	3.5 ft-lb/in	187 J/m	ASTM D-256
Tensile Strength @ Yield	7,100 psi	49 MPa	ASTM D-638
Tensile Elongation @ Break	16 %	16 %	ASTM D-638
Flexural Modulus	366,000 psi	2,525 MPa	ASTM D-790
<b>Thermal Properties</b>			
DTUL @ 66 psi (455 kPa)	197 Deg. F	92 Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	182 Deg. F	84 Deg. C	ASTM D-648

All tests are performed on dry as molded ASTM test bars.

**General Product Type Information**

DYN-ABS, is also available with internal and external lubricants, UV stabilized and other modifications. Manufactured with recycled content. Further information and details are available upon request.

**Processing Information**

Temperatures		F	C
Barrel	Rear	370 - 425	189 - 220
	Center	400 - 450	206 - 234
	Front	425 - 475	220 - 248
	Nozzle	425 - 525	220 - 276
	Mold	120 - 170	49 - 77

**Drying**

Type	Dehumidifier
Temperature	180°F - 200°F
Time	2 hours
Max. % Moisture	0.10

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Dynamic Polymer Solutions disclaims any liability for loss or damage incurred in connection with the use of this product. Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.