

ABS BM662B

Blow Molding

Description

Blow Molding, Heat Resistance

Application

Automotives Exterior Housing
(Spoiler, Bumper Guard etc)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.05
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.7
Melt Flow Rate	220°C/10kg	ASTM D1238	g/10min	2
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	460
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	30
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm ²	720
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm ²	21,500
IZOD Impact Strength, 6.4mm (Notched)	23 °C	ASTM D256	kg·cm/cm	13
	-30 °C		kg·cm/cm	7
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg·cm/cm	13
	-30 °C		kg·cm/cm	7
Rockwell Hardness	R-Scale	ASTM D785	-	101
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	100
	4.6kg		°C	108
Vicat Softening Temperature	1kg, 120°C/h	ASTM D1525	°C	106
Flammability		UL94		
Relative Temperature Index		UL 746B		
Electrical			°C	
Mechanical with Impact			°C	
Mechanical without Impact			°C	

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : 18-Jan-12

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Electrical

Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	-
Surface Resistivity		IEC 60093	Ohm	-
Volume Resistivity	23 °C	ASTM D257	Ohm·m	-
Arc Resistance	23 °C	ASTM D495	Ohm·cm	-
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	-
Dielectric Constant (10 ⁶ Hz)	23 °C	ASTM D150	sec	-

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Processing Guide (Blow Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	80~90
Drying Time		hrs	3~4
Minimum Moisture Content		%	0.01
Melt Temperature		°C	200~210
Barrel Temperature	Zone 1	°C	180~200
	Zone 2	°C	190~210
	Zone 3	°C	190~210
	Zone 4	°C	200~220
Adapter Temperature		°C	220
Die Temperature		°C	220
Roll Stack Temperature	Top	°C	-
	Middle	°C	-
	Bottom	°C	-

Note) Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.

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