

Calsak CS-72 General Purpose ABS Resin

Category : Polymer , Thermoplastic , ABS Polymer , Acrylonitrile Butadiene Styrene (ABS), Impact Grade, Molded

Material Notes:

Product Characteristics: High Impact, High Gloss Injection molding grade

Order this product through the following link:

http://www.lookpolymers.com/polymer_Calsak-CS-72-General-Purpose-ABS-Resin.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.05 g/cc	1.05 g/cc	ASTM D792
Melt Flow	5.0 g/10 min	5.0 g/10 min	ASTM D1238
	@Load 3.80 kg, Temperature 230 °C	@Load 8.38 lb, Temperature 446 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	109	109	ASTM D785
Tensile Strength, Yield	42.1 MPa	6100 psi	Type I; ASTM D638
	@Thickness 3.17 mm	@Thickness 0.125 in	
Elongation at Break	30 %	30 %	ASTM D638
Tensile Modulus	2.55 GPa	370 ksi	Type I; ASTM D638
	@Thickness 3.17 mm	@Thickness 0.125 in	
Flexural Strength	72.4 MPa	10500 psi	ASTM D790
	@Thickness 3.17 mm	@Thickness 0.125 in	
Flexural Modulus	2.62 GPa	380 ksi	ASTM D790
	@Thickness 3.17 mm	@Thickness 0.125 in	
Izod Impact, Notched	3.74 J/cm	7.00 ft-lb/in	ASTM D256
	@Thickness 3.17 mm	@Thickness 0.125 in	

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	85.0 °C	185 °F	Unannealed; ASTM D648
	@Thickness 3.17 mm	@Thickness 0.125 in	
	94.4 °C	202 °F	Annealed; ASTM D648
	@Thickness 3.17 mm	@Thickness 0.125 in	
Vicat Softening Point	106 °C	223 °F	ASTM D1525

Thermal Properties	HB Metric	HB English	Comments
	@Thickness 1.59 mm	@Thickness 0.0625 in	

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	235 - 249 °C	455 - 480 °F	
Middle Barrel Temperature	241 - 254 °C	465 - 490 °F	
Front Barrel Temperature	246 - 260 °C	475 - 500 °F	
Nozzle Temperature	246 - 260 °C	475 - 500 °F	
Melt Temperature	246 - 302 °C	475 - 575 °F	
Mold Temperature	43.3 - 65.6 °C	110 - 150 °F	
Drying Temperature	82.2 - 87.8 °C @Time 7200 sec	180 - 190 °F @Time 2.00 hour	
Injection Pressure	68.9 - 110 MPa	10000 - 16000 psi	
Back Pressure	0.000 - 0.172 MPa	0.000 - 25.0 psi	
Clamp Pressure	13.8 - 27.6 MPa	2000 - 4000 psi	

Descriptive Properties	Value	Comments
Hold Pressure	50 - 75% of injection pressure	
Injection Speed	High	
Screw Speed	Moderate	

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