

# MABS TR552

## Injection Molding

### Description

Transparency, High Impact, Chemical Resistance

### Application

Electric&Electronic Products

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.06
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	12
<b>Mechanical</b>				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm <sup>2</sup>	400
Tensile Elongation, 3.2mm @ Yield	50mm/min	ASTM D638	%	
@ Break	50mm/min		%	35
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm <sup>2</sup>	620
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm <sup>2</sup>	18,700
IZOD Impact Strength, 6.4mm (Notched)	23℃	ASTM D256	kg-cm/cm	23
IZOD Impact Strength, 3.2mm (Notched)	23℃	ASTM D256	kg-cm/cm	23
Rockwell Hardness	R-Scale	ASTM D785	-	100
<b>Thermal</b>				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	℃	82
<b>Optical</b>				
Haze		ASTM D1003	%	2.2
Transparency		ASTM D1003	%	90

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℃, 50% relative humidity.

Updated : 5-Sep-11

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### Processing Guide(Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	80~90
Drying Time		hrs	2 ~ 4
Minimum Moisture Content		%	0.01
Melt Temperature		℃	210 ~ 240
Cylinder Temperature	Rear	℃	190 ~ 210
	Middle	℃	200 ~ 220
	Front	℃	210 ~ 230
Nozzle Temperature		℃	210 ~ 240
Mold Temperature		℃	40 ~ 60
Back Pressure		kg/cm <sup>2</sup>	300 ~ 600
Screw Speed		rpm	under 80

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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