

# MABS TR557

Injection Molding

## Description

## Application

Electric&Electronic Products

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.09
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	23
<b>Mechanical</b>				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm <sup>2</sup>	460
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	
@ Break	50mm/min		%	30
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm <sup>2</sup>	740
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm <sup>2</sup>	22,600
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23℃		kg-cm/cm	17
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg-cm/cm	16
Rockwell Hardness	R-Scale	ASTM D785	-	109
<b>Thermal</b>				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	81
<b>Optical</b>				
Haze		ASTM D1003	%	2.0
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	℃	190 ~ 220	
Cylinder Temperature	Rear	℃	180 ~ 200
	Middle	℃	190 ~ 210
	Front	℃	200 ~ 220
Nozzle Temperature	℃	190 ~ 220	
Mold Temperature	℃	40 ~ 60	
Back Pressure	kg/cm <sup>2</sup>	300 ~ 600	
Screw Speed	rpm	30 ~ 60	

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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