

SH610A

Description

SH610A is an ABS product for extrusion, designed to have very high impact strength and low fluidity.

Key Features

High Impact Strength

Application

General Extruded Sheet

Properties	Condition	Method	Unit	SH610A
Physical				
Specific Gravity	23°C	ASTM D792		1.04
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.7
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	5
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	41
Tensile Elongation at Break	23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	10
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	63
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	2050
Izod Impact Strength	Notched, 3.2mm, 23°C	ASTM D256	J/m	490
Izod Impact Strength	Notched, 3.2mm, -30°C	ASTM D256	J/m	210
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	420
Izod Impact Strength	Notched, 6.4mm, -30°C	ASTM D256	J/m	190
Rockwell Hardness	R-Scale	ASTM D785		97
Thermal				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	87
Vicat Softening Temperature	50N, 50°C/h	ASTM D1525	°C	94

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors. Values given should not be interpreted as specification and not be used for designing part or tool.

All properties, except melt flow index are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

Updated Date : 2021-05-07 Issued Date : 2021-05-14

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Processing Guide (Extrusion)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Moisture Content	%	~ 0.01
Extrusion Temperature	°C	180 ~ 250

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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