

## Technical Data Sheet

# 710 ABS

### PRODUCT DESCRIPTION:

ABS710 is a plating grade ABS resin, offering high rigidity, high flow and high impact. ABS710 is recommended for automobile parts, cosmetics cases, refrigerator knobs, etc.

### FEATURES:

- High rigidity
- High impact

### APPLICATION:

- Decklid applique
- Chrome plated grill & Trim

Properties	Standard	Condition	Unit	Typical Value
<b>Physical</b>				
Density	ISO 1183	23°C	g/cm <sup>3</sup>	1.04
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.4-0.7
Melt Flow Rate	ISO 1133	220°C, 10kg	g/10 min	25
<b>Mechanical</b>				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	41
Flexural Strength	ISO 178	2mm/min	MPa	62
Flexural Modulus	ISO 178	2mm/min	MPa	2200
Notched Charpy Impact	ISO 179	4J, 23°C	kJ/m <sup>2</sup>	25
Notched Charpy Impact	ISO 179	4J, -30°C	kJ/m <sup>2</sup>	13
Unnotched Charpy Impact	ISO 179	4J, 23°C	kJ/m <sup>2</sup>	NB
<b>Thermal</b>				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	80
Heat Deflection Temperature	ISO 75	120°C/hr, 0.45MPa	°C	90
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	94
<b>Other Properties</b>				
Flammability	ISO 3795	360*100*3 mm	mm/min	≤80

Processing Parameters		Value	Unit
<b>Pre-treatment</b>			
Drying Temperature		80 ~ 85	°C
Drying Time		3 ~ 4	hour
Maximum Moisture Content		≤0.05	%
<b>General Guidelines</b>			
Barrel Temperature	Rear	190 ~ 210	°C
	Middle	210 ~ 220	°C
	Front	225 ~ 235	°C
Nozzle		220 ~ 230	°C
Melt Temperature		220 ~ 230	°C
		50 ~ 80	°C

**Note :**

1. Values are measured at 23°C and in RH of 50% on injection molded specimens.
2. Typical values for uncolored products, not specifications, and may vary slightly with different colors.
3. Flexural strength is tested with fixed deflection.
4. HDT: specimens are unannealed.
5. The general guidelines are only for reference. Exact settings have to follow the product and machine conditions.

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