

Technical Data Sheet

K7024

ABS

PRODUCT DESCRIPTION:

ABS K7024 is a plating grade ABS resin, offering high rigidity, high flow and high impact. ABS K7024 is recommended for external automobile parts.

FEATURES:

- High rigidity
- High impact

APPLICATION:

- Decklid applique
- Chrome plated grill & Trim

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	23°C	g/cm ³	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
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	42
Tensile Elogation at Break	ISO 527	50mm/min	%	30
Flexural Strength	ISO 178	2mm/min	MPa	63
Flexural Modulus	ISO 178	2mm/min	MPa	2100
Notched Izod Impact	ISO 179	5.5J, 23°C	kJ/m ²	25
Notched Izod Impact	ISO 179	5.5J, -30°C	kJ/m ²	12
Unnotched Izod Impact	ISO 179	5.5J, 23°C	kJ/m ²	NB
Thermal				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	75
Heat Deflection Temperature	ISO 75	120°C/hr, 0.45MPa	°C	85
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	95
Other Properties				
Flammability	ISO 3795	360*100*3 mm	mm/min	≤80

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