

MP220

Injection Molding

Description

- High Adhesion Metal Plating ABS

Applications

- Automobile Radiator Grill, Molding

Properties	Method	Unit	MP220
Physical			
Specific Gravity , 23°C	ISO 1180		1.04
Mold Shrinkage , 23°C, 3.2mm , 23°C	ISO 294-4	%	0.4 ~ 0.7
Melt Volume Rate , 220°C, 10kg	ISO 1133	cm ³ /10min	20
Mechanical			
Tensile Strength at Yield , 23°C, 50mm/min, 4mm	ISO 527	MPa	44
Tensile Elongation at Break , 23°C, 50mm/min, 4mm	ISO 527	%, (Min)	25
Tensile Modulus , 23°C, 50mm/min, 4mm	ISO 527	MPa	2200
Flexural Strength , 23°C, 2mm/min, 4mm	ISO 178	MPa	65
Flexural Modulus , 23°C, 2mm/min, 4mm	ISO 178	MPa	2300
Izod Impact Strength , Notched, 4mm, 23°C	ISO 180/1A	kJ/m ²	25
Izod Impact Strength , Notched, 4mm, -30°C	ISO 180/1A	kJ/m ²	14
Charpy Impact Strength , 4mm, 23°C	ISO 179/1eA	kJ/m ²	26
Charpy Impact Strength , 4mm, -30°C	ISO 179/1eA	kJ/m ²	14
Rockwell Hardness , R-Scale	ISO 2039		110
Thermal			
HDT , Flatwise, 1.8MPa, 4mm, Unannealed	ISO 75	°C	83
HDT , Flatwise, 0.45MPa, 4mm, Unannealed	ISO 75	°C	94
HDT , Flatwise, 1.8MPa, 4mm, Annealed	ISO 75	°C	93
HDT , Flatwise, 0.45MPa, 4mm, Annealed	ISO 75	°C	103
VICAT , 50N, 50°C/h	ISO 306	°C	100

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 rate are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Moisture Content	%	0.05 ~
Melt Temperature	°C	230 ~ 250
Nozzle Temperature	°C	220 ~ 270
Mold Temperature	°C	40 ~ 80
Back Pressure, Hydraulic Type	kg/cm ²	10 ~ 30

Note

Back Pressure & Measuring 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.