



## Technical Data Sheet

Grade

ABS D2100

**Product Description:**

ABS Standard Gloss High Impact Natural

Physical Properties	Method	English	SI
Specific Gravity	D 792	-	1.050
Melt Flow Rate (230/3.8)	D 1238	-	7.0 g/10 minutes
Melt Flow Rate (220/10)	D 1238	-	22 g/10 minutes
Linear Mold Shrinkage (Typical)	D 955	0.006 in/in	0.006 mm/mm
Mechanical Properties	Method	English	SI
Tensile Strength at Yield	D 638	5600 psi	38.62 Mpa
Tensile Elongation at Break	D 638	35 %	35 %
Flexural Modulus (Tangent)	D 790	305000 psi	2100 Mpa
Izod Impact (notched)	D 256	6.0 ft-lb/in	320 J/m
Thermal Properties	Method	English	SI
Heat Deflection Temperature at 66 psi	D 648	195 F	91 C
Heat Deflection Temperature at 264 psi	D 648	185 F	85 C
Processing (Injection Molding)		English	SI
Drying Temperature		175 F	79 C
Drying Time		4 hrs	4 hrs
Max Moisture Content		0.20 %	0.20 %
Rear Barrel Temperature		455 F	235 C
Middle Barrel Temperature		465 F	241 C
Front Barrel Temperature		475 F	246 C
Nozzle Temperature		475 F	246 C
Stock Temperature		480 F	249 C
Mold Temperature		130 F	54 C

**Comments:**

none

Values shown are averages and not to be construed as specifications.

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