

# TECHNO ABS 400

Acrylonitrile Butadiene Styrene  
Techno Polymer Co, Ltd.

General		
Features	• Good Chemical Resistance	
Processing Method	• Injection Molding	
Physical	Nominal Value Unit	Test Method
Density	1.05 g/cm <sup>3</sup>	ISO 1183 ASTM D1505
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	23 g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.60 %	ISO 294-4
Mechanical	Nominal Value Unit	Test Method
Tensile Strength		
Yield	54.9 MPa	ASTM D638
Yield	49.0 MPa	ISO 527-2
Flexural Modulus		
--	2940 MPa	ASTM D790
--	2400 MPa	ISO 178
Flexural Strength		
--	93.2 MPa	ASTM D790
--	76.0 MPa	ISO 178
Impact	Nominal Value Unit	Test Method
Charpy Notched Impact Strength	16 kJ/m <sup>2</sup>	ISO 179
Notched Izod Impact	170 J/m	ASTM D256
Hardness	Nominal Value Unit	Test Method
Rockwell Hardness		
R-Scale	114	ASTM D785
R-Scale	109	ISO 2039-2
Thermal	Nominal Value Unit	Test Method
Deflection Temperature Under Load		
0.45 MPa, Unannealed	93.0 °C	ASTM D648
0.45 MPa, Unannealed	79.0 °C	ISO 75-2/B
Flammability	Nominal Value Unit	Test Method
Flame Rating - UL (ALL)	HB	UL 94
UL File Number	E54297	
Injection	Nominal Value Unit	
Drying Temperature	80.0 to 90.0 °C	
Drying Time	2.0 to 5.0 hr	
Rear Temperature	190 to 260 °C	
Middle Temperature	190 to 260 °C	
Front Temperature	190 to 260 °C	
Mold Temperature	40.0 to 80.0 °C	