



EXPERIENCE CREDIBLE PROCESS

Acrylonitrile Butadiene Styrene (ABS) Specification

Grade 1 (HR2320)

Supplier 1

No.	Property	unit	Test method	value
1	MELT FLOW INDEX (200°C/5KG)	GR/10 MIN	ASTM D-1238	1.2
2	IZOD IMPACT STRENGTH	KJ/M2	ASTM D-256	20
3	VICAT SOFTENING POINT	°C	ASTM D-1525	103
4	BULK DENSITY	KG/M3	-	600
5	TENSILE STRENGTH AT YIELD	KGF/CM2	ASTM D-638	470
6	TENSILE STRENGTH AT BREAK	KGF/CM2	ASTM D-638	450
7	ELONGATION AT YIELD	%	ASTM D-638	4
8	ELONGATION AT BREAK	%	ASTM D-638	90
9	FLEXURAL STRENGTH AT YIELD	KGF/CM2	ASTM D-790	600
10	FLEXURAL MODULUS	KGF/CM2	ASTM D-790	21000
11	HDT (0.45 MPA & 120°C/HR)	°C	ASTM D-648	87
12	ROCKWELL HARDNESS (AT 23°C)	GR/10MIN	ASTM D-1238	107



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Grade 2 (HR2340)

Supplier 1

No.	Property	unit	Test method	value
1	MELT FLOW INDEX (200°C/5KG)	GR/10 MIN	ASTM D-1238	1
2	IZOD IMPACT STRENGTH	KJ/M2	ASTM D-256	40
3	VICAT SOFTENING POINT	°C	ASTM D-1525	112
4	BULK DENSITY	KG/M3	-	600
5	TENSILE STRENGTH AT YIELD	KGF/CM2	ASTM D-638	480
6	TENSILE STRENGTH AT BREAK	KGF/CM2	ASTM D-638	470
7	ELONGATION AT YIELD	%	ASTM D-638	4
8	ELONGATION AT BREAK	%	ASTM D-638	110
9	FLEXURAL STRENGTH AT YIELD	KGF/CM2	ASTM D-790	600
10	FLEXURAL MODULUS	KGF/CM2	ASTM D-790	22000
11	HDT (0.45 MPA & 120°C/HR)	°C	ASTM D-648	94
12	ROCKWELL HARDNESS (AT 23°C)	GR/10MIN	ASTM D-1238	110



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