

Grade: CAB 21A-UZ

Technical Data Sheet

Type: Injection molding, ABS

Application: Typical household appliances.

Properties	Test Method	Unit	Values
Physical properties			
Density	ISO 1183	gm/cm ³	1.05±0.01
Melt Flow Rate (220°C, 10kg)	ISO 1133	gm/10min	≥21
Shrinkage (48h after molding)	ISO 294	%	0.4 to 0.7
Mechanical properties			
Tensile Stress at yield	ISO 527	Mpa	≥45
Flexural Modulus	ISO 178	Mpa	≥2200
Nothched Charpy Impact (23°C)	ISO 179-1	kJ/m ²	≥20
Nothched Charpy Impact (-30°C)	ISO 179-1	kJ/m ²	≥10
Rockwell Hardness	ISO 2039	R-Scale	110
Thermal properties			
Vicat softening	ISO 306	°C	≥90
HDT (1.8 MPa)	ISO 75	°C	≥78

Processing Guide (Injection Molding)

Processing Parameters		Unit	Values
Drying Temperature		°C	80
Drying Time		hrs	3-4
Minimum Moisture Content		%	0.3
Melt Temperature		°C	220 ~ 250
Cylinder Temperature	Rear	°C	200 ~ 210
	Middle	°C	210 ~ 230
	Front	°C	225 ~ 250
Nozzle Temperature		°C	225~ 250
Mold Temperature		°C	50 ~ 95
Back Pressure		Bar	3.0 ~ 15

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