Shuman Plastics
Resourceful. Responsive. Responsible. Since 1947.

TECHNICAL DATA SHEET

Shuman Compound:

ABS 710 Utility black, 720 Black, 730 White, 780 Grey

Offers this combination of properties:

Good impact strength, Easy processability

TYPICAL PROPERTIES

MECHANICAL PROPERTIES	VALUE	UNITS	TEST METHODS
Izod Impact Strength (Notched, 1/8" Thick Specimen)	4.0 (+/- 0.5)	FT-LBS/IN	ASTM D-256
Rockwell Hardness	102	R	ASTM D-785
THERMAL PROPERTIES			
Heat Deflection Temperature @ 264 PSI	169	deg. F	ASTM D-648
OTHER PROPERTIES			
Specific Gravity	1.04		ASTM D-792
Melt Flow Rate	4 (+/-2)	GM/10 MIN.	ASTM D-1238

SUGGESTED PROCESSING CONDITIONS

DRYING CONDITIONS:	TEMPERATURE (deg. F) MIN.	TEMPERATURE (deg. F) MAX.	TIME (HOURS) MIN.	TIME (HOURS) MAX.
Dehumidifying Dryer	190	200	2	24
Tray Dryer NOTE: Depth of granules in tray dryer should not exceed 1½ in. (38.1 mm)	170	200	4	24

TEMPERATURE CONDITIONS:

INJECTION: 400 - 440F
EXTRUSION: 350 – 420F

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