

Properties

MX5

ABS resin

For plating

Properties	Test methods	Test conditions	Units	
Melt mass-flow rate	ISO 1133	220 deg C/10kg	g/10min	12
Mold shrinkage	Daicel method	-	%	0.4-0.6
Tensile strength	ISO 527	-	MPa	49
Flexural strength	ISO 178	-	MPa	67
Flexural modulus	ISO 178	-	MPa	2300
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	24
Deflection temperature under load	ISO 75	1.80MPa	deg C	82
Density	ISO 1183	-	g/cm3	1.04

Note

- Test methods such as ISO standards are fully or almost compliant with the standards.
- Values are typical, not quality assured.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
3-5hrs 80-85deg C	210-230	210-230	190-210	170-190	70-90	10-20	40-60