



Technical Datasheet

Ver. 2018

Material Type ABS	Grade Name 4330A
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Features	<ul style="list-style-type: none"> • High Rigidity • Medium Heat Resistance • Low Emission
Material Standard	GMW 15572-T2/DBL 5404.80
Availability	North America/Asia-Pacific
Process Method	Injection Molding
Appearance	Colors Optional
Applications	Automotive Interior and Exterior Parts

General Properties					
No.	Properties	Methods	Units	Values	Test Conditions
1	Density	ISO 1183-1	g/cm ³	1.05	23°C
2	Tensile Strength at Max Load	ISO 527-2	MPa	46	50mm/min
3	Flexural Strength	ISO 178	MPa	67	2mm/min
4	Flexural Modulus	ISO 178	MPa	2200	2mm/min
5	Notched Impact Strength	ISO 179-1	kJ/m ²	17	23°C
6	Notched Impact Strength	ISO 179-1	kJ/m ²	10	-30°C
7	Melt Flow Rate	ISO 1133-1	g/10min	12	220°C×10kg
8	Vicat Softening Temp.	ISO 306	°C	102	B50
9	Heat Deflection Temp.	ISO 75-2	°C	82	1.8MPa,120°C/h
10	Flammability (Burn Rate)	ISO 3795	mm/min	40	

Processing Conditions	
Drying Cond.	• 80-90°C * 2-4h Moisture Control • < 0.05
Injection Temp.	• 230-240 °C(F), 220-230 °C(M), 200-210 °C(B)
Injection Speed	• Low to Medium
Injection Pressure	• 70-110 MPa
Back Pressure	• 0.3-0.7 MPa
Mold Temp.	• 50-80 °C

Note : The technical data above are authentic and reliable for reference. These values cannot be defined as the minimal performance value.