



Technical Datasheet

Ver. 2018

Material Type	ABS	Grade Name	4330HI
Features	<ul style="list-style-type: none">• High Impact Resistance• Low Emission• Medium Heat Resistance		
Material Standard	GS 93016/DBL 5404		
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	1.04	23°C
2	Tensile Strength at Max Load	ISO 527-2	MPa	38	50mm/min
3	Flexural Strength	ISO 178	MPa	60	2mm/min
4	Flexural Modulus	ISO 178	MPa	2000	2mm/min
5	Notched Impact Strength	ISO 179-1	kJ/m ²	30	23°C
6	Notched Impact Strength	ISO 179-1	kJ/m ²	15	-30°C
7	Melt Flow Rate	ISO 1133-1	g/10min	5	220°C×10kg
8	Vicat Softening Temp.	ISO 306	°C	96	B50
9	Heat Deflection Temp.	ISO 75-2	°C	78	1.8MPa,120°C/h
10	Flammability (Burn Rate)	ISO 3795	mm/min	40	

Processing Conditions

Drying Cond.	<ul style="list-style-type: none">• 80-90°C * 2-4h	Moisture Contro	<ul style="list-style-type: none">• < 0.05
Injection Temp.	<ul style="list-style-type: none">• 230-240 °C(F), 220-230 °C(M), 200-210 °C(B)		
Injection Speed	<ul style="list-style-type: none">• Low to Medium		
Injection Pressure	<ul style="list-style-type: none">• 70-110 MPa		
Back Pressure	<ul style="list-style-type: none">• 0.3-0.7 MPa		
Mold Temp.	<ul style="list-style-type: none">• 50-80 °C		

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