

**Dayson Polymers, LLC**  
**ABS PORENE® GA800 Property Data Sheet**  
**Acrylonitrile Butadiene Styrene**  
**High Impact/High Gloss**

Property	Test Condition	Nominal Values (English)	Test Method
<b>Physical</b>			
Melt Flow Rate	220°C/10.0kg	20 g/10 min	ASTM D1238
Mold Shrink, Linear-Flow		0.0040 to 0.0060 in/in	ASTM D955
<b>Mechanical</b>			
Tensile Strength @ Yield		7,530 psi	ASTM D638
Flexural Modulus		341,040 psi	ASTM D790
Flexural Strength @ Yield		10,200 psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact	73°F, 0.250 in	4.96	ASTM D256
<b>Hardness</b>			
Rockwell Hardness	R-Scale	118	ASTM D785
<b>Thermal</b>			
DTUL @ 264 psi - Unannealed		189 °F	ASTM D648
DTUL @ 66 psi - Unannealed		205 °F	ASTM D648
<b>Ignition Characteristics</b>			
Flame Rating – UL		HB	UL-94
<b>PROCESSING INFORMATION</b>			
<b>Injection Molding Parameters</b>		<b>Nominal Values (English)</b>	
Drying Temperature		176 to 185 °F	
Drying Time		2.0 to 3.0 hr	
Processing (Melt) Temp		356 to 482 °F	
Mold Temperature		104 to 140 °F	

**APPLICATION: INJECTION MOLDING**  
**APPLIANCES, CALCULATORS, HOUSINGS, TOYS**

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