

CELEX™ 730GS
ABS Resin

Overview

CELEX 730GS is a 30% glass fiber reinforced ABS resin. It is designed with high rigidity and good dimensional stability. CELEX 730GS is designed for use in computer cooling fan, fax machine chassis, monitor base and air-conditioner parts.

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.25 g/cm ³	1.25 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	3.0 g/10 min	3.0 g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in (3.20 mm))	2.0E-3 to 4.0E-3 in/in	0.20 to 0.40 %	ASTM D955
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus (0.126 in (3.20 mm))	776000 psi	5350 MPa	ASTM D638
Tensile Strength (Yield, 0.126 in (3.20 mm))	12500 psi	86.0 MPa	ASTM D638
Flexural Modulus (0.126 in (3.20 mm))	885000 psi	6100 MPa	ASTM D790
Flexural Strength (0.126 in (3.20 mm))	15700 psi	108 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	1.8 ft-lb/in	98 J/m	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	212 °F	100 °C	
Injection	Nominal Value (English)	Nominal Value (SI)	
Drying Temperature	185 °F	85 °C	
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr	
Rear Temperature	356 to 374 °F	180 to 190 °C	
Middle Temperature	374 to 428 °F	190 to 220 °C	
Front Temperature	374 to 428 °F	190 to 220 °C	
Nozzle Temperature	392 to 446 °F	200 to 230 °C	
Mold Temperature	140 to 176 °F	60 to 80 °C	