

## CELEX™ 720GS ABS Resin

### Overview

CELEX 720GS is a 20% glass fiber reinforced ABS resin. It is designed with high rigidity and good dimensional stability. CELEX 720GS 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	1.17 g/cm <sup>3</sup>	1.17 g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	2.5 g/10 min	2.5 g/10 min	ASTM D1238
Molding Shrinkage - Flow	3.0E-3 to 5.0E-3 in/in	0.30 to 0.50 %	
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus			ASTM D638
0.126 in (3.20 mm), Injection Molded	612000 psi	4220 MPa	
Tensile Strength			ASTM D638
Yield, 0.126 in (3.20 mm), Injection Molded	10700 psi	74.0 MPa	
Flexural Modulus			ASTM D790
0.126 in (3.20 mm), Injection Molded	658000 psi	4540 MPa	
Flexural Strength			ASTM D790
0.126 in (3.20 mm), Injection Molded	14600 psi	101 MPa	
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm), Injection Molded	2.6 ft-lb/in	140 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), Injection Molded	210 °F	99.0 °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	