

Artisan™ AR7300-5006 HQS Piano Black

Acrylonitrile Butadiene Styrene

Key Characteristics

Product Description

ABS compound with good flowability for high gloss and piano black injection molded applications.

General

Material Status	• Commercial: Active
Regional Availability	• Europe
Features	• Good Flow • Good Surface Finish • High Gloss
RoHS Compliance	• RoHS Compliant
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.10 g/cm ³	1.10 g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	25 g/10 min	25 g/10 min	ISO 1133
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus (73°F (23°C))	305000 psi	2100 MPa	ISO 527-1
Tensile Stress (Yield, 73°F (23°C))	6530 psi	45.0 MPa	ISO 527-2
Tensile Stress (Break, 73°F (23°C))	4350 psi	30.0 MPa	ISO 527-2
Tensile Strain (Yield, 73°F (23°C))	3.0 %	3.0 %	ISO 527-2
Tensile Strain (Break, 73°F (23°C))	> 15 %	> 15 %	ISO 527-2
Flexural Modulus (73°F (23°C))	334000 psi	2300 MPa	ISO 178
Flexural Stress (73°F (23°C))	9430 psi	65.0 MPa	ISO 178
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact Strength (73°F (23°C))	> 5.2 ft·lb/in ²	> 11 kJ/m ²	ISO 180
Unnotched Izod Impact Strength (73°F (23°C))	> 21 ft·lb/in ²	> 45 kJ/m ²	ISO 180
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.06 in (1.6 mm))	HB	HB	UL 94
Glow Wire Ignition Temperature 0.04 in (1.0 mm)	1200 °F	650 °C	IEC 60695-2-13

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Max Moisture	< 0.020 %	< 0.020 %
Processing (Melt) Temp	392 to 464 °F	200 to 240 °C
Mold Temperature	104 to 158 °F	40 to 70 °C
Injection Rate	Slow-Moderate	Slow-Moderate

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Injection Notes

Maintain back pressure and screw recovery speed as low as possible for best appearance. A dryer with an inlet dew point under -30 degrees Celsius is recommended. Refer to the Artisan ABS processing guide for additional molding guidance.

Notes

¹ Typical values are not to be construed as specifications.

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