ABS-70

Classification: General purpose
Characteristic: Super High Impact Resistance
Characteristic: Automobile parts (radiator grill & etc.), Helmets, Toys, Suitcase, Profiles Released extruded product, Bobbin sleeve, Boats, pipe, bath tubs & etc.

### TECHNICAL DATA SHEET

**Property** | **Test method (ASTM)** | **Test condition** | **Unit** | **Typical value** | **ABS-70 Speciation**
--- | --- | --- | --- | --- | ---
Izod impact | D-256 | 6.4 mm, notched | Kj/m² | 26 | MIN23
Melt flow index | D-1238 | 220°C, 10 kg | gr/10 min | 14 | 8-16
Rock well hardness | D-785 | ........ | R-scale | 113 | 100-120
HDT | D-648 | 1.82 m pa | °c | 90 | MIN85
Vicat softening Temp | D-1527 | 5kg/50°C | °c | 100 | MIN96
Tensile strength | D-638 | 23°C, 50 mm/min | Kg/cm² | 470 | MIN440
Tensile elongation | D-628 | 23°C, 50 mm/min | % | 25 | MIN18
Flexural strength | D-790 | 23°C, 2.8 mm/min | Kg/cm² | 670 | MIN650
Flexural Modulus | D-790 | 23°C, 2.8 mm/min | Kg/cm² | 23000 | MIN20000
Specific Gravity | D-792 | ........ | Kg/cm² | 1.04 | 1.04
Molding Shrinkage | D-955 | ........ | % | 0.4-0.7 | 0.4-0.7
Flammability | Ul94 | 1/8 inch (3.2 mm) | HB | HB | HB

**TYPICAL ABS PROCESSING CONDITIONS**

Drying: it is recommended that GBPC ABS Resins be dried at (80-85°C) for 3 hours.
Extruder with one-stage or two-stage venting are recommended for extrusion of sheet, compression ratios should be between 2.5/1 and 3.0/1 for a single stage screw and L/D ratios 20/1 is typical.

### INJECTION MOLDING CONDITION

Some modifications may be required depending on the specific molding equipment and part configuration.

<table>
<thead>
<tr>
<th>Rear Temp (°c)</th>
<th>Center Temp (°c)</th>
<th>Center Temp (°c)</th>
<th>Front Temp (°c)</th>
<th>Nozzle Temp (°c)</th>
<th>Melt Temp (°c)</th>
</tr>
</thead>
<tbody>
<tr>
<td>190-200</td>
<td>200-210</td>
<td>210-220</td>
<td>245-225</td>
<td>225-235</td>
<td>240</td>
</tr>
</tbody>
</table>

Mold Temp (°c) | Filling Speed | Slow-Med