

ABS-50

Classification: General purpose

Characteristic: Medium Impact, High rigidity

Application: Electronic and Electrical parts, vacuum cleaner, washing machine cover and Refrigerator door cap & etc

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| Property | Test method (ASTM) | Test condition | Unit | Typical value | ABS-50 Specification |
|----------------------|--------------------|-------------------|--------------------|---------------|----------------------|
| Izod impact | D-256 | 6.4 mm , notched | Kj/m ² | 23 | Min19 |
| Melt flow index | D-1238 | 220°C , 10 kg | gr/10 min | 35 | 29-39 |
| Rock well hardness | D-785 | | R-scale | 109 | 95-115 |
| HDT | D-648 | 1.82 m pa | °c | 85 | Min82 |
| Vicat softening Temp | D-1525 | 5kg/50°C | °c | 95 | Min 93 |
| Tensile strength | D-638 | 23°C , 50 mm/min | Kg/cm ² | 455 | Min 420 |
| Tensile elongation | D-638 | 23°C , 50 mm/min | % | 20 | Min 16 |
| Flexural strength | D-790 | 23°C , 2.8 mm/min | Kg/cm ² | 650 | Min 620 |
| Flexural Modulus | D-790 | 23°C , 2.8 mm/min | Kg/cm ² | 22000 | Min17000 |
| Specific Gravity | D-792 | 23°C | .. | 1.04 | 1.04 |
| Molding Shrinkage | D-955 | ... | % | 0.4-0.7 | 0.4-0.7 |
| Flammability | U194 | 1/8inch(3.2mm) | ... | HB | HB |

TYPICAL ABS PROCESSING CONDITIONS

DRYING: it is recommended that GBPC ABS Resins be dried at (80-85°C)for 3 hours.

The following molding conditions are recommended starting point for GBPC ABS Resin. A moisture level of ≤0.1% should be reached before injection molding the resin.

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

INJECTION MOLDIN

| Rear Temp(°c) | Center Temp (°c) | Center Temp (°c) | Front Temp (°c) | Nozzle Temp (°c) | Melt Temp (°c) |
|----------------|------------------|------------------|-----------------|------------------|----------------|
| 190-200 | 200-210 | 210-220 | 210-220 | 215-225 | 230 |
| Mold Temp (°c) | Filling Speed | | | | |
| 60-80 | Slow-Med | | | | |