

ABS-30

Classification: General ABS>Heat Resistance grade

Characteristic: Semi Heat Resistance grade

Application: Mirror housings, Hair dryer shells, Electric oven exterior parts, Automobile parts and etc.

Property	Test method	Test condition	Unit	Typical value	ABS-30 specificatio
Izod impact	D-256	6.4 mm , notched	Kj/m ²	20	Min16
Melt flow index	D-1238	200 ^o c , 5kg 220 ^o c , 10 kg	gr/10 min	1.2 10	0.9-1.5 6-14
Rock well hardness	D-785	R-scale	108	100-120
HDT	D-648	1.82 m pa	^o c	93	Min91
Vicat softening Temp	D-1525	5kg/50 ^o c	^o c	1.3	Min 100
Tensile strength	D-638	23 ^o c , 50 mm/min	Kg/cm ²	460	Min 440
Tensile elongation	D-638	23 ^o c , 50 mm/min	%	25	Min 16
Flexural strength	D-790	23 ^o c , 2.8 mm/min	Kg/cm ²	650	Min 630
Flexural Modulus	D-790	23 ^o c , 2.8 mm/min	Kg/cm ²	21000	Min18000
Specific Gravity	D-792	23 ^o c	..	1.04	1.04
Molding Shrinkage	D-955	...	%	0.4-0.7	0.4-0.7
Flammability	UI94	1/8inch(3.2mm)	...	HB	HB

TYPICAL ABS PROCESSING CONDITIONS

DRYING: it is recommended that GBPC ABS Resins be dried at (80-85^oc)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)
200-210	210-220	210-220	220-230	230-240	250
Mold Temp (°c)	Filling Speed				
60-70	Slow-Med				