

ABS-GH-500

Classification: Special grade/ultra high heat resistance

Characteristic: Ultra Heat Resistance& No odor

Application: Automobile parts and Electronic parts and etc.

Property	Test method	Test condition	Unit	Typical value	ABS-40 specificatio
Izod impact	D-256	6.4 mm , notched	Kj/m ²	16	Min14
Melt flow index	D-1238	220°C , 10 kg	gr/10 min	6	4-10
Rock well hardness	D-785	R-scale	110	100-120
HDT	D-648	1.82 m pa	°c	11	Min107
Vicat softening Temp	D-1525	5kg/50°C	°c	12	Min 120
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	470	Min450
Tensile elongation	D-638	23°C , 50 mm/min	%	22	Min20
Flexural strength	D-790	23°C , 2.8 mm/min	Kg/cm ²	700	Min 680
Flexural Modulus	D-790	23°C , 2.8 mm/min	Kg/cm ²	23500	Min20000
Specific Gravity	D-792	23°C	..	1.05	1.05
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°C)for 3 hours.

moisture level of ≤ 0.1% should be reached before injection molding the resin.

The following molding conditions are recommended starting point for GBPC ABS Resin. Some modifications may be required depending on the specific molding equipment and part configuration.

Injection Molding

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	220-240	250
Mold Temp (°c)	Filling Speed				
60-70	Slow-Med				