

ABS- HFA 70

Classification: General grade ABS>Flame retardant

Characteristic: medium Impact Strength > Flame retardant

Application: Electrical and Electronic parts, TV, VTR, Printer, facsimile, computer, monitor & requiring flame retardant property..

Property	Test method	Test condition	Unit	Typical value	ABS-40 specificatio
Izod impact	D-256	6.4 mm , notched	Kj/m ²	21	Min18
Melt flow index	D-1238	220°C , 10 kg	gr/10 min	50	40-50
Rock well hardness	D-785	R-scale	112	95-115
HDT	D-648	1.82 m pa	°c	84	Min82
Vicat softening Temp	D-1525	5kg/50°C	°c	94	Min 93
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	440	Min420
Tensile elongation	D-638	23°C , 50 mm/min	%	30	Min18
Flexural strength	D-790	23°C , 2.8 mm/min	Kg/cm ²	650	Min 630
Flexural Modulus	D-790	23°C , 2.8 mm/min	Kg/cm ²	20000	Min18000
Specific Gravity	D-792	23°C	..	1.16	1.16
Molding Shrinkage	D-955	...	%	0.4-0.7	0.4-0.7
Flammability	UI94	1/8inch(3.2mm)	...	V-0	V-0

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)
160-170	170-180	180-190	190-200	195-205	210
Mold Temp (°c)	Filling Speed				
60-80	Slow-Med				