

ABS-28

Classification: General purpose

Characteristic: Super high gloss High rigidity

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

Property	Test method (ASTM)	Test condition	Unit	Typical Value	ABS-28 Specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	17	Min16
Melt flow index	D-1238	220°C , 10 kg	gr/10 min	35	25-35
Rock well hardness	D-785		R-scale	107	105-120
HDT	D-648	1.82 m pa	°c	85	Min85
Vicat softening Temp	D-1525	5kg/50°C	°c	95	Min95
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	500	Min 440
Tensile elongation	D-638	23°C , 50 mm/min	%	15	Min 14
Flexural strength	D-790	23°C , 2.8 mm/min	Kg/cm ²	680	Min 630
Flexural Modulus	D-790	23°C , 2.8 mm/min	Kg/cm ²	22500	Min 18500
Specific Gravity	D-792	23°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°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				