

ABS-30

Classification: General A B S >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 (ASTM)	Test condition	Unit	Typical value	ABS-30 specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	20	Min16
Melt flow index	D-1238	200°C , 5 kg	gr/10 min	1.2	0.9-1.5
		220°C , 10 kg		10	6-14
Rock well hardness	D-785		R-scale	108	100-120
HDT	D-648	1.82 m pa	°C	93	Min91
Vicat softening Temp	D-1525	5kg/50°C	°C	103	Min100
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	460	Min 440
Tensile elongation	D-638	23°C , 50 mm/min	%	25	Min 16
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	21000	Min 18000
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 Heat Resistance Resins be dried at (80-90°C) for 3 hours. A 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 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				