

ABS-65

Classification: General grade.

Characteristic: General plating, poor solvent paint.

Application: Electronic and Electrical parts, Automobile parts, Refrigerator knobs, Motorcycle parts, house appliances, Cosmetic case, etc.

Property	Test method (ASTM)	Test condition	Unit	Typical value	ABS-65 Specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	30	Min25
Melt flow index	D-1238	220°C , 10 kg	gr/10 min	25	20-30
Rock well hardness	D-785		R-scale	110	95-115
HDT	D-648	1.82 m pa	°C	85	Min82
Vicat softening Temp	D-1525	5kg/50°C	°C	95	Min 93
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	450	Min 410
Tensile elongation	D-638	23°C , 50 mm/min	%	27	Min 25
Flexural strength	D-790	23°C , 2.8 mm/min	Kg/cm ²	640	Min 550
Flexural Modulus	D-790	23°C , 2.8 mm/min	Kg/cm ²	21000	Min19000
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	220-230	230
Mold Temp (°C)	Filling Speed				
60-80	Slow-Med				