

ABS-70SR

Classification: General purpose>Extrusion grade

Characteristic: Extrusion grade, high impact Resistance

Application: Refrigerator interior container and door liner (cyclopentane Blowing agent use)
, automotive parts, piping, etc.

Property	Test method (ASTM)	Test condition	Unit	Typical value	ABS-70SR Specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	27	MIN25
Melt flow index	D-1238	220°C , 10 kg	gr/10 min	10	7-14
Rock well hardness	D-785		R-scale	112	100-120
HDT	D-648	1.82 m pa	°C	87	MIN82
Vicat softening Temp	D-1525	5kg/50°C	°C	97	MIN94
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	470	MIN440
Tensile elongation	D-638	23°C , 50 mm/min	%	25	MIN16
Flexural strength	D-790	23°C , 2.8 mm/min	Kg/cm ²	660	MIN630
Flexural Modulus	D-790	23°C , 2.8 mm/min	Kg/cm ²	23000	MIN18000
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.

Extruder with one-stage or two-stage venting are recommended for extrusion of sheet. compression ratios should be between 2.5/1 and 3.0/1 for a single stage screw and L/D ratios 20/1 is typical.

Zone 1(°C)	Zone 2(°C)	Zone 3(°C)	Zone 4(°C)	Zone 5(°C)	Zone 6(°C)	Zone 7(°C)
190-200	190-200	200-210	200-210	210-220	210-220	210-220

Adapter(°C)	Die zone(°C)	Screen Pack Mesh (2layer)		
210-220	225-235	#60-80		