

ABS/ASA

Extrusion Grade 170

Property	Test method (ASTM)	Test condition	Unit	Typical value
Izod impact	D-256	6.4 mm , notched	Kj/m ²	35
Melt flow index	D-1238	220°C , 10 kg	gr/10 min	6
Rock well hardness	D-785		R-scale	105
HDT	D-648	1.82 m pa	°c	85
Vicat softening Temp	D-1525	5kg/50°C	°c	95
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	480
Tensile elongation	D-638	23°C , 50 mm/min	%	20
Flexural strength	D-790	23°C , 2.8 mm/min	Kg/cm ²	690
Flexural Modulus	D-790	23°C , 2.8 mm/min	Kg/cm ²	21000
Specific Gravity	D-792	23°C	..	1.04
Molding Shrinkage	D-955	...	%	0.4-0.7
Flammability	UL94	1/8 inch (3.2mm)	...	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)
190-210	210-230	220-240	225-245	225-245	225-245	225-245

Adapter(°c)	Outer Die zone(°c)	Mid Die zone (°C)	Center Die zone (°C)	Screen Pack Mesh (2layer)
225-245	225-235	220-240	220-240	#40 / #80 / #80 / #40
Nip Roll Top (°C)	Nip Roll Middle (°C)	Nip Roll Bottom (°C)	Die Lip Thickness (mm)	Head Pressure
50-70	60-80	70-90	3.2-4.0	140 bar