

ABS-ER-72M

Classification: General purpose>Extrusion grade

Characteristic: Extrusion grade, High rigidity& high impact strength, Low Heat Impact Strength.

Application: Refrigerator interior container and door liner (HCFC-141b Blowing agent use) and etc.

Property	Test method (ASTM)	Test condition	Unit	Typical value	ABS-ER72M Specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	36	MIN33
Melt flow index	D-1238	220°C , 10 kg	gr/10 min	6	3-8
Rock well hardness	D-785		R-scale	105	100-120
HDT	D-648	1.82 m pa	°C	85	MIN84
Vicat softening Temp	D-1525	5kg/50°C	°C	95	MIN92
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	430	MIN420
Tensile elongation	D-638	23°C , 50 mm/min	%	30	MIN18
Flexural strength	D-790	23°C , 2.8 mm/min	Kg/cm ²	620	MIN620
Flexural Modulus	D-790	23°C , 2.8 mm/min	Kg/cm ²	19000	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

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 and Gear pump are recommended for extrusion of sheet.
 compression ratios should be between 2.5/1and3.0/1 for a single stage screw and L/D ratios> 30(L/D<30) 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	230-245	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		