

ABS/GF

High Heat Resistance

75 G20

Property	Test method (ASTM)	Test condition	Unit	Typical value
Izod impact	D-256	6.4 mm , notched	Kj/m ²	10
Melt flow index	D-1238	220°C , 10 kg	gr/10 min	7
Rock well hardness	D-785		R-scale	117
HDT	D-648	1.82 m pa	°C	100
Vicat softening Temp	D-1525	5kg/50°C	°C	110
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	750
Tensile elongation	D-638	23°C , 50 mm/min	%	5
Flexural strength	D-790	23°C , 2.8 mm/min	Kg/cm ²	1200
Flexural Modulus	D-790	23°C , 2.8 mm/min	Kg/cm ²	45000
Specific Gravity	D-792	23°C	..	1.2
Filler Content			%	18-22
Molding Shrinkage	D-955	...	%	0.1-0.3
Flammability	UI94	1/8inch(3.2mm)	...	HB

ABS Processing Conditions

Moisture levels in pellets and drying techniques the moisture level of the pellets used has to be kept below a specific limit if the moldings are to have satisfactory surface and good properties. The moisture level in ABS/GF 75 G20 pellets should not exceed 0.1%. Drying at 80 to 90 °C for 4 hours.

Injection Molding Condition

The heat needed to melt the pellets is supplied by external heating of the plastifying cylinder and also by the friction from rotation of the screw. The temperature profile options shown in table 1 are available when setting heater band temperatures.

Rear Temp (°C)	Center Temp (°C)	Center Temp(°C)	Front Temp(°C)	Nozzle Temp(°C)	Melt Temp(°C)
200-210	210-220	220-230	230-240	230-250	240
Mold Temp (°C)	Filing Speed	Back pressure	Injection Speed		
65-80	Slow (20-40rpm)	50-100 Psi (lower is better)	Lower is better		