ABS-GH-500

Classification: Special grade/ultra high heat resistance

Characteristic: Ultra Heat Resistance& No odor

Application: Automobile parts and Electronic parts and etc.

Property	Test method (ASTM)	Test condition	Unit	Typical value	ABS-GH-500 specification
Izod impact	D-256	6.4 mm , notched	Kj/m²	16	Min14
Melt flow index	D-1238	220ºc , 10 kg	gr/10 min	6	4-10
Rock well hardness	D-785	.....	R-scale	110	100-120
HDT	D-648	1.82 m pa	ºc	110	Min107
Vicat softening Temp	D-1525	5kg/50°c	ºc	128	Min120
Tensile strength	D-638	23ºc , 50 mm/min	Kg/cm²	470	Min 450
Tensile elongation	D-638	23ºc , 50 mm/min	%	22	Min 20
Flexural strength	D-790	23ºc , 2.8 mm/min	Kg/cm²	700	Min 680
Flexural Modulus	D-790	23ºc , 2.8 mm/min	Kg/cm²	23500	Min 20000
Specific Gravity	D-792	23ºc	..	1.05	1.05
Molding Shrinkage	D-955	…	%	0.4-0.7	0.4-0.7
Flammability	Ul94	1/8inch(3.2mm)	…	HB	HB

TYPICAL ABS PROCESSING CONDITIONS

DRYING: it is recommended that GBPC ABS Heat Resistance Resins be dried at (80-90°c) for 3 hours. A moisture level of ≤0.1% should be reached before injection molding the resin.

The following molding conditions are recommended starting point for GBPC ABS 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)
200-210	210-220	210-220	220-230	220-240	250

Mold Temp (°c)	Filling Speed			
60-70	Slow-Med			

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