TECHNICAL DATA SHEET **SIRJANGOSTAR**
GLOBAL GROUP CO. **SGGC**

ABS-HFA 70

Classification: General grade ABS>Flame retardant
Characteristic: medium Impact Strength > Flame retardant
Application: Electrical and Electronic part s, TV, VTR, Printer, facsimile, computer, monitor & requiring Flameretardant property.

Property	Test method (ASTM)	Test condition	Unit	Typical value	Final Product specification
Izod impact	D-256	6.4 mm , notched	Kj/m²	21	Min18
Melt flow index	D-1238	220ºc , 10 kg	gr/10 min	50	40-50
Rock well hardness	D-785	.....	R-scale	112	95-115
HDT	D-648	1.82 m pa	ºc	84	Min82
Vicat softening Temp	D-1525	5kg/50°c	ºc	94	Min 93
Tensile strength	D-638	23ºc , 50 mm/min	Kg/cm²	440	Min 420
Tensile Elongation	D-638	23ºc , 50 mm/min	%	30	Min 18
Flexural strength	D-790	23ºc , 2.8 mm/min	Kg/cm²	650	Min 630
Flexural Modulus	D-790	23ºc , 2.8 mm/min	Kg/cm²	20000	Min18000
Specific Gravity	D-792	23ºc	..	1.16	1.16
Molding Shrinkage	D-955	…	%	0.4-0.7	0.4-0.7
Flammability	Ul94	1/16inch(1.6mm)	…	V-0	V-0

TYPICAL ABS PROCESSING CONDITIONS

DRYING: it is recommended that GBPC ABS Resins be dried at (80-85°c)for 2 hours.

The following molding conditions are recommended starting point for GBPC ABS Resin. A moisture level of ≤0.1% should be reached before injection molding the 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)
160-170	170-180	180-190	190-200	195-205	210
Mold Temp (°c)	Filling Speed				
60-80	Slow-Med				

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