

GAC 250

PC/ABS Alloy: Non Reinforced Grade

Classification: General purpose>Injection grade

Characteristic: Injection grade, high impact Resistance

Application GAC 250 resin gives exceptional impact strength even at low temperature and has a high Heat resistance. Typical applications include automotive instrument panel, automotive interior and exterior trim. Electrical and Electronic component and etc.

Property	Test method (ASTM)	Test condition	Unit	Typical value	GBEAC 250 Specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	45	Min40
Melt flow index	D-1238	230°C , 21.6 kg	gr/10 min	47	45-55
Rock well hardness	D-785		R-scale	113	100-120
HDT	D-648	1.82 m pa	°C	125	Min115
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	550	Min520
Tensile elongation	D-638	23°C , 50 mm/min	%	100	Min80
Flexural strength	D-790	23°C , 2.8 mm/min	Kg/cm ²	835	Min780
Flexural Modulus	D-790	23°C , 2.8 mm/min	Kg/cm ²	22500	Min19000
Specific Gravity	D-792	23°C	..	1.08	1.08
Molding Shrinkage	D-955	...	%	0.5-0.7	0.5-0.7
Flammability	UI94	1/8inch(3.2mm)	...	HB	HB

TYPICAL PC/ABS PROCESSING CONDITIONS

The following molding conditions are recommended starting point for GBPC PC/ABS alloy. A moisture level of $\leq 0.1\%$ should be reached before injection molding the resin.

Some modifications may be required depending on the specific molding equipment and part configuration.

DRYING: it is recommended that GBPC PC/ ABS Resins be dried at (80-95°C)for 3 hours.

INJECTION MOLDIN

Rear Temp(°C)	Center Temp (°C)	Center Temp (°C)	Front Temp (°C)	Nozzle Temp (°C)	Melt Temp (°C)
230-240	230-240	240-250	250-260	260-270	260

Mold Temp (°C)	Filling Speed			
70-80	Slow-Med			