

ABS-10

Classification: General grade.

Characteristic: General plating and electro plating use

Application: Electronic and Electrical parts, Automobile parts, Refrigerator knobs, Cosmetic case

Property	Test method (ASTM)	Test condition	Unit	Typical value	ABS-10 specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	30	Min24
Melt flow index	D-1238	220°c , 10 kg	gr/10 min	32	26-34
Rock well hardness	D-785	R-scale	105	95-115
HDT	D-648	1.82 m pa	°c	84	Min82
Vicat softening Temp	D-1525	5kg/50°c	°c	94	Min 93
Tensile strength	D-638	23°c , 50 mm/min	Kg/cm ²	420	Min 380
Tensile elongation	D-638	23°c , 50 mm/min	%	25	Min 16
Flexural strength	D-790	23°c , 2.8 mm/min	Kg/cm ²	600	Min 560
Flexural Modulus	D-790	23°c , 2.8 mm/min	Kg/cm ²	19500	Min17000
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

TYPICAL ABS PROCESSING CONDITIONS

DRYING: it is recommended that GBPC ABS Resins be dried at (80-85°c)for 3 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)
190-200	200-210	210-220	210-220	215-225	230
Mold Temp (°c)	Filling Speed				
60-80	Slow-Med				