

ABS-60

Classification: General grade.

Characteristic: General plating , strong solvent paint.

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

Property	Test method (ASTM)	Test condition	Unit	Typical value	ABS-60 Specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	25	Min23
Melt flow index	D-1238	220°c , 10 kg	gr/10 min	15	10-20
Rock well hardness	D-785	R-scale	112	100-120
HDT	D-648	1.82 m pa	°c	87	Min85
Vicat softening Temp	D-1525	5kg/50°c	°c	97	Min96
Tensile strength	D-638	23°c , 50 mm/min	Kg/cm ²	455	Min440
Tensile elongation	D-638	23°c , 50 mm/min	%	22	Min20
Flexural strength	D-790	23°c , 2.8 mm/min	Kg/cm ²	670	Min650
Flexural Modulus	D-790	23°c , 2.8 mm/min	Kg/cm ²	22000	Min20000
Specific Gravity	D-792	23°c	..	1.04	1.04
Molding Shrinkage	D-955	...	%	0.4-0.7	0.4-0.7
Flammability	U194	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	220-230	230
Mold Temp (°c)	Filling Speed				

60-80	Slow-Med			
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