

SAN-1

Classification: General grade.

Characteristic: high flow

Application: ABS Compounding ,ABS/PC Compounding,Cups,cosmetic container, Blower fan, pencil case, juicer, stereo dust cover&etc

Property	Test method (ASTM)	Test condition	Unit	Typical value	SAN-1 Specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	1.5	Min 2
Melt flow index	D-1238	220°c , 10 kg	gr/10 min	30	28-32
Rock well hardness	D-785	M-scale	83	Min81
HDT	D-648	1.82 m pa	°c	92	Min 88
Vicat softening Temp	D-1525	5kg/50°c	°c	105	Min 98
Tensile strength	D-638	23°c , 50 mm/min	Kg/cm ²	680	Min 620
Flexural strength	D-790	23°c , 2.8 mm/min	Kg/cm ²	750	Min 670
Flexural Modulus	D-790	23°c , 2.8 mm/min	Kg/cm ²	31500	Min 31000
Water Absorbtion	D-570	24 hr,immersion in water	%	0.3	0.3
Specific Gravity	D-792	23°c	..	1.04	1.04
Molding Shrinkage	D-955	...	%	0.2~0.6	0.2~0.6
Flammability	UI94	1/8inch(3.2mm)	...	HB	HB

TYPICAL SAN PROCESSING CONDITIONS

DRYING: it is recommended that GBPC SAN 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				