

ABS-HFA 70

Classification: General grade ABS>Flame retardant

Characteristic: medium Impact Strength > Flame retardant

Application: Electrical and Electronic part s,TV,VTR,Printer,facsmilie,computer,monitor&requiring flame retardant property.

| Property | Test method (ASTM) | Test condition | Unit | Typical value | Final Product specification |
|----------------------|--------------------|-------------------|--------------------|---------------|-----------------------------|
| Izod impact | D-256 | 6.4 mm , notched | Kj/m ² | 21 | Min18 |
| Melt flow index | D-1238 | 220°c , 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 | °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 | 440 | Min 420 |
| Tensile Elongation | D-638 | 23°c , 50 mm/min | % | 30 | Min 18 |
| Flexural strength | D-790 | 23°c , 2.8 mm/min | Kg/cm ² | 650 | Min 630 |
| Flexural Modulus | D-790 | 23°c , 2.8 mm/min | Kg/cm ² | 20000 | Min18000 |
| Specific Gravity | D-792 | 23°c | .. | 1.16 | 1.16 |
| Molding Shrinkage | D-955 | ... | % | 0.4-0.7 | 0.4-0.7 |
| Flammability | UI94 | 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 | | | | |