

SAN-4

Classification: General grade.

Characteristic: super high strength

Application: ABS Compounding, disposable lighter, pounding, Electrical & electronic parts, & etc

| Property | Test method (ASTM) | Test condition | Unit | Typical value | SAN-4 Specification |
|----------------------|--------------------|--------------------------|--------------------|---------------|---------------------|
| Izod impact | D-256 | 6.4 mm , notched | Kj/m ² | 1.5 | Min 1.5 |
| Melt flow index | D-1238 | 220°C , 10 kg | gr/10 min | 6 | 4-7 |
| Rock well hardness | D-785 | | M-scale | 89 | Min88 |
| HDT | D-648 | 1.82 m pa | °c | 92 | Min 90 |
| Vicat softening Temp | D-1525 | 5kg/50°c | °c | 108 | Min 99 |
| Tensile strength | D-638 | 23°c , 50 mm/min | Kg/cm ² | 850 | Min 800 |
| Flexural strength | D-790 | 23°c , 2.8 mm/min | Kg/cm ² | 1150 | Min 1200 |
| Flexural Modulus | D-790 | 23°c , 2.8 mm/min | Kg/cm ² | 33000 | Min 32500 |
| 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 | | | | |