

AKSAD GROUP PETROCHEM

ABS-40

Classification:

General Purpose

Characteristic:

High Impact Resistance

Application:

Automobile parts (radiator grill & etc.), Helmets, Toys, Suitcase, Shoe heels, skis, golf club heads, Sports equipment, suitcases, & etc.

Properties	Test Method (ASTM)	Test Condition	Unit	Typical Value	ABS-40 specification
Izod impact	D-256	6.4 mm, notched	Kj/m2	32	Min 26
Melt flow index	D-1238	220c°, 10g	Gr/10min	25	18-28
Rock well hardness	D-785	-	R-scale	98	90-110
HDT	D-648	1.82 m pa	C°	82	Min 82
Vicat Softening Temp	D-1525	5kg/50 c°	C°	92	Min 93
Tensile strength	D-638	23 c°, 50 mm/min	Kg/cm2	400	Min 390
Tensile elongation	D-638	23 c°, 50 mm/min	%	30	Min 25
Flexural strength	D-790	23 c°, 2.8 mm/min	Kg/cm2	580	Min 530
Flexural Modulus	D-790	23 c°, 2.8 mm/min	Kg/cm2	18000	Min 15000
Specific Gravity	D-792	23 c°	-	1.04	1.04
Molding Shrinkage	D-955	-	%	0.4-0.7	0.4-0.7
Flammability	UI94	1/8 inch(3.2mm)	-	HB	HB

Typical ABS Processing Conditions:

Drying: It is recommended that ABS Resin 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 MOLDING

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				