

Ghaed ABS/PC GAC 265

Polycarbonate + ABS

Ghaed Basir Petrochemicals Co.

Message:

PC/ABS Alloy : Non Reinforced Grade
Classification: General purpose>Injection grade
Characteristic: Injection grade, Ultra high impact Resistance
Application GAC 265 resin gives exceptional impact strength even at low temperature and has a highheat resistance. Typical applications include automotive instrument panel, automotive interior and exteriortrim .This resin is particularly suited for thin wall molding.

General Information			
Features	General Purpose		
	High Heat Resistance		
	Low Temperature Impact Resistance		
	Ultra High Impact Resistance		
Uses	Automotive Exterior Parts		
	Automotive Instrument Panel		
	Automotive Interior Parts		
	Thin-walled Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/21.6 kg)	30 to 40	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105 to 125		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 23°C)	> 53.9	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C)	> 95	%	ASTM D638
Flexural Modulus ³ (23°C)	> 1860	MPa	ASTM D790
Flexural Strength ⁴ (23°C)	> 78.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁵	> 55	kJ/m ²	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	> 118	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (3.20 mm)	HB		UL 94
Injection	Nominal Value	Unit	

Drying Temperature	80.0 to 95.0	°C
Drying Time	3.0	hr
Suggested Max Moisture	< 0.10	%
Rear Temperature	230 to 240	°C
Middle Temperature	230 to 260	°C
Front Temperature	250 to 270	°C
Nozzle Temperature	260 to 270	°C
Processing (Melt) Temp	270	°C
Mold Temperature	70.0 to 80.0	°C
Injection Rate	Slow-Moderate	

NOTE

- | | |
|----|------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 2.8 mm/min |
| 4. | 2.8 mm/min |
| 5. | 6.4mm |

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