

Ghaed ABS/PC GAC 244

Polycarbonate + ABS

Ghaed Basir Petrochemicals Co.

Message:

PC/ABS Alloy : Non Reinforced Grade

Classification: General purpose>Injection grade

Characteristic: Injection grade, high impact Resistance

Application: GAC 244 is an unreinforced PC/ABS alloy which offers good impact strength and high heatresistance. Especially, metal plating is very easy with GAC 244. So GAC 244 could be used outdoorhousing which need metal plating such as, automotive door handle, lamp housing, etc

General Information			
Features	General Purpose		
	High Heat Resistance		
	High Impact Resistance		
	Platable		
Uses	Automotive Interior Trim		
	Electrical Housing		
	Outdoor Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/21.6 kg)	35 to 45	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)	90 to 110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 23°C)	> 44.1	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C)	> 90	%	ASTM D638
Flexural Modulus ³ (23°C)	> 1770	MPa	ASTM D790
Flexural Strength ⁴ (23°C)	> 73.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁵	> 38	kJ/m ²	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	> 115	°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 250	°C
Front Temperature	250 to 260	°C
Nozzle Temperature	260 to 270	°C
Processing (Melt) Temp	260	°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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