

Ghaed ABS ABS-HU-650

Acrylonitrile Butadiene Styrene
Ghaed Basir Petrochemicals Co.

Message:

Classification: General ABS>Heat Resistance grade
Characteristic: Ultra Heat Resistance& High impact strength
Application: Mirror housings, Hair dryer shells, Electric oven exterior parts, Automobile parts and etc.

General Information			
Features	General Purpose		
	High Heat Resistance		
	High Impact Resistance		
Uses	Appliance Components		
	Automotive Applications		
	Electric Motor Housings		
	Housings		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	1.0 to 4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100 to 120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 23°C)	> 43.1	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C)	> 16	%	ASTM D638
Flexural Modulus ³ (23°C)	> 1960	MPa	ASTM D790
Flexural Strength ⁴ (23°C)	> 65.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁵	> 16	kJ/m ²	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	> 105	°C	ASTM D648
Vicat Softening Temperature	> 128	°C	ASTM D1525 ⁶
Flammability	Nominal Value		Test Method
Flame Rating (3.20 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	

Drying Time	3.0	hr
Suggested Max Moisture	< 0.10	%
Rear Temperature	200 to 210	°C
Middle Temperature	210 to 220	°C
Front Temperature	220 to 230	°C
Nozzle Temperature	220 to 240	°C
Processing (Melt) Temp	250	°C
Mold Temperature	60.0 to 70.0	°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 |
| 6. | Rate A (50°C/h), Loading 2 (50 N) |

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