

Ghaed ABS ABS-75

Acrylonitrile Butadiene Styrene

Ghaed Basir Petrochemicals Co.

Message:

Classification: General purpose>Extrusion grade

Characteristic: Extrusion grade, High rigidity& high impact strength

Application: Refrigerator interior container and door liner(cyclopentane Blowing agent use) and etc.

General Information			
Features	Rigidity, high		
	Impact resistance, high		
	General		
Uses	Home appliance components		
Processing Method	Extrusion		
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)	4.0 - 10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95 - 115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 23°C)	> 39.2	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C)	> 25	%	ASTM D638
Flexural Modulus ³ (23°C)	> 1770	MPa	ASTM D790
Flexural Strength ⁴ (23°C)	> 63.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ⁵	> 33	kJ/m ²	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	> 84.0	°C	ASTM D648
Vicat Softening Temperature	> 93.0	°C	ASTM D1525 ⁶
Flammability	Nominal Value		Test Method
Flame Rating (3.20 mm)	HB		UL 94
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0 - 85.0	°C	
Drying Time	3.0	hr	
Cylinder Zone 1 Temp.	190 - 210	°C	
Cylinder Zone 2 Temp.	210 - 230	°C	
Cylinder Zone 3 Temp.	220 - 240	°C	

Cylinder Zone 4 Temp.	225 - 245	°C
Cylinder Zone 5 Temp.	225 - 245	°C
Adapter Temperature	225 - 245	°C
Die Temperature	220 - 245	°C
Take-Off Roll	50.0 - 90.0	°C

Extrusion instructions		
Compression Ratio: 2.5:1 to 3:1L/D Ratio: >30:1Zone 6: 225 to 245°CZone 7: 225 to 245°CScreen Pack Mesh (2 layer): # 40 / #80 / #80 / #40Die Lip Thickness (mm): 3.2-4.0Head pressure: 140 bar		

NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	2.8 mm/min	
4.	2.8 mm/min	
5.	6.4mm	
6.	速率 A (50°C/h), 载荷2 (50N)	

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