

Ghaed ABS ABS-70

Acrylonitrile Butadiene Styrene

Ghaed Basir Petrochemicals Co.

Message:

Classification: General purpose

Characteristic: Super High Impact Resistance

Characteristic: Automobile parts(radiator grill &etc.),Helmets,Toys,Suitcase,Profiles Released extruded product ,Bobbin sleeve, Boats, pipe, bath tubs&etc.

General Information			
Features	Ultra-high impact resistance		
	General		
Uses	Water Sports Equipment		
	Safety helmet		
	Piping system		
	Leather case		
	Application in Automobile Field		
	Toys		
	spool		
	Profile		
	Bathroom accessories		
Processing Method	Extrusion		
	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)	8.0 - 16	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100 - 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)	> 18	%	ASTM D638
Flexural Modulus ³ (23°C)	> 1960	MPa	ASTM D790
Flexural Strength ⁴ (23°C)	> 63.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ⁵	> 23	kJ/m ²	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed)	> 85.0	°C	ASTM D648
Vicat Softening Temperature	> 96.0	°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 - 85.0	°C	
Drying Time	3.0	hr	
Rear Temperature	190 - 200	°C	
Middle Temperature	200 - 220	°C	
Front Temperature	225 - 245	°C	
Nozzle Temperature	225 - 235	°C	
Processing (Melt) Temp	240	°C	
Mold Temperature	60.0 - 80.0	°C	
Injection Rate	Slow-Moderate		
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0 - 85.0	°C	
Drying Time	3.0	hr	
Cylinder Zone 1 Temp.	190 - 200	°C	
Cylinder Zone 2 Temp.	190 - 200	°C	
Cylinder Zone 3 Temp.	200 - 210	°C	
Cylinder Zone 4 Temp.	200 - 210	°C	
Cylinder Zone 5 Temp.	210 - 220	°C	
Adapter Temperature	210 - 220	°C	
Die Temperature	225 - 235	°C	
Extrusion instructions			
Compression Ratio: 2.5:1 to 3:1L/D Ratio: 20:1Zone 6: 210 to 220°CZone 7: 210 to 220°CScreen Pack Mesh (2 layer): #60-80			
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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