

ABS-70

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.

Property	Test method (ASTM)	Test condition	Unit	Typical value	ABS-70 Specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	26	MIN23
Melt flow index	D-1238	220°c , 10 kg	gr/10 min	14	8-16
Rock well hardness	D-785	R-scale	113	100-120
HDT	D-648	1.82 m pa	°c	90	MIN85
Vicat softening Temp	D-1525	5kg/50°c	°c	100	MIN96
Tensile strength	D-638	23°c , 50 mm/min	Kg/cm ²	470	MIN440
Tensile elongation	D-638	23°c , 50 mm/min	%	25	MIN18
Flexural strength	D-790	23°c , 2.8 mm/min	Kg/cm ²	670	MIN650
Flexural Modulus	D-790	23°c , 2.8 mm/min	Kg/cm ²	23000	MIN20000
Specific Gravity	D-792	23°c	..	1.04	1.04
Molding Shrinkage	D-955	...	%	0.4-0.7	0.4-0.7
Flammability	UI94	1/8inch(3.2mm)	...	HB	HB

TYPICAL ABS PROCESSING CONDITIONS

DRYING: it is recommended that ABS Resins be dried at (80-85°c) for 3 hours.

Extruder with one-stage or two-stage venting are recommended for extrusion of sheet. Compression ratios should be between 2.5/1and3.0/1 for a single stage screw and L/D ratios 20/1 is typical.

Zone 1(°c)	Zone 2(°c)	Zone 3(°c)	Zone 4(°c)	Zone 5(°c)	Zone 6(°c)	Zone 7(°c)
190-200	190-200	200-210	200-210	210-220	210-220	210-220
Adapter(°c)	Die zone(°c)	Screen Pack Mesh (2layer)				
210-220	225-235	#60-80				

INJECTION MOLDIN CONDITION

Some modifications may be required depending on the specific molding equipment and part configuration.

Rear Temp(°c)	Center Temp (°c)	Center Temp (°c)	Front Temp (°c)	Nozzle Temp (°c)	Melt Temp (°c)
190-200	200-210	210-220	245-225	225-235	240
Mold Temp (°c)	Filling Speed				
60-80	Slow-Med				