



ABS-50

Classification: General purpose

Characteristic: Medium Impact, High rigidity

Application: Electronic and Electrical parts, vacuum cleaner, washing machine cover and Refrigerator door cap & etc

Property	Test method (ASTM)	Test condition	Unit	Typical value	ABS-50 Specification
Izod impact	D-256	6.4 mm , notched	Kj/m ²	23	Min19
Melt flow index	D-1238	220°C , 10 kg	gr/10 min	35	29-39
Rock well hardness	D-785	R-scale	109	95-115
HDT	D-648	1.82 m pa	°c	85	Min82
Vicat softening Temp	D-1525	5kg/50°C	°c	95	Min 93
Tensile strength	D-638	23°C , 50 mm/min	Kg/cm ²	455	Min 420
Tensile elongation	D-638	23°C , 50 mm/min	%	20	Min 16
Flexural strength	D-790	23°C , 2.8 mm/min	Kg/cm ²	650	Min 620
Flexural Modulus	D-790	23°C , 2.8 mm/min	Kg/cm ²	22000	Min17000
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.

The following molding conditions are recommended starting point for ABS Resin. A moisture level of ≤0.1% should be reached before injection molding the resin.

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

INJECTION MOLDING

Rear Temp(°c)	Center Temp (°c)	Center Temp (°c)	Front Temp (°c)	Nozzle Temp (°c)	Melt Temp (°c)
190-200	200-210	210-220	210-220	215-225	230
Mold Temp (°c)	Filling Speed				
60-80	Slow-Med				