ABS-80

Classification: General purpose

Characteristic: Hi Flow, 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-80 Specification
Izod impact	D-256	6.4 mm , notched	Kj/m²	20	Min16
Melt flow index	D-1238	220°c , 10 kg	gr/10 min	52	45-55
Rock well hardness	D-785	.....	R-scale	110	100-120
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/cm²	470	Min 450
Tensile elongation	D-638	23°c , 50 mm/min	%	19	Min 14
Flexural strength	D-790	23°c , 2.8 mm/min	Kg/cm²	670	Min 650
Flexural Modulus	D-790	23°c , 2.8 mm/min	Kg/cm²	22000	Min20000
Specific Gravity	D-792	23°c	..	1.04	1.04
Molding Shrinkage	D-955	…	%	0.4-0.7	0.4-0.7
Flammability	Ul94	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 MOLDIN

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			