

Ghaed ABS ABS-10

Acrylonitrile Butadiene Styrene
Ghaed Basir Petrochemicals Co.

Message:

Classification: General grade.
Characteristic: General plating and electro plating use
Application: Electronic and Electrical parts, Automobile parts, Refrigerator knobs, Cosmetic case

General Information			
Features	General Purpose		
	Platable		
Uses	Appliance Components		
	Automotive Applications		
	Cosmetics		
	Electrical/Electronic Applications		
Processing Method	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)	26 to 34	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95 to 115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 23°C)	> 37.3	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C)	> 16	%	ASTM D638
Flexural Modulus ³ (23°C)	> 1670	MPa	ASTM D790
Flexural Strength ⁴ (23°C)	> 54.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁵	> 24	kJ/m ²	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	> 82.0	°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
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 95.0	°C	
Drying Time	3.0	hr	

Suggested Max Moisture	< 0.10	%
Rear Temperature	190 to 200	°C
Middle Temperature	200 to 220	°C
Front Temperature	210 to 220	°C
Nozzle Temperature	215 to 225	°C
Processing (Melt) Temp	230	°C
Mold Temperature	60.0 to 80.0	°C
Injection Rate	Slow-Moderate	

NOTE

- | | |
|----|-----------------------------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 2.8 mm/min |
| 4. | 2.8 mm/min |
| 5. | 6.4mm |
| 6. | Rate A (50°C/h), Loading 2 (50 N) |

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