

Ghaed ABS ABS-70SR

Acrylonitrile Butadiene Styrene
Ghaed Basir Petrochemicals Co.

Message:

Classification: General purpose>Extrusion grade
Characteristic: Extrusion grade, high impact Resistance
Application: Refrigerator interior container and door liner(cyclopentane Blowing agent use), automotive parts, Piping, etc.

General Information			
Features	Impact resistance, high		
	General		
Uses	Piping system		
	Home appliance components		
	Application in Automobile Field		
Processing Method	Extrusion		
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)	7.0 - 14	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)	> 16	%	ASTM D638
Flexural Modulus ³ (23°C)	> 1770	MPa	ASTM D790
Flexural Strength ⁴ (23°C)	> 61.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ⁵	> 25	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	> 94.0	°C	ASTM D1525 ⁶
Flammability	Nominal Value		Test Method
Flame Rating (3.20 mm)	HB		UL 94
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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