

# Ghaed ABS ABS-HFA-70

Acrylonitrile Butadiene Styrene

Ghaed Basir Petrochemicals Co.

## Message:

Classification: General grade ABS>Flame retardant

Characteristic: medium Impact Strength > Flame retardant

Application: Electrical and Electronic part s,TV,VTR,Printer,facsmilie,computer,monitor&requiring flame retardant property.

| General Information                                     |                                    |                   |                         |
|---------------------------------------------------------|------------------------------------|-------------------|-------------------------|
| Features                                                | Flame Retardant                    |                   |                         |
|                                                         | General Purpose                    |                   |                         |
|                                                         | Medium Impact Resistance           |                   |                         |
| Uses                                                    | Business Equipment                 |                   |                         |
|                                                         | Electrical/Electronic Applications |                   |                         |
| Processing Method                                       | Injection Molding                  |                   |                         |
| Physical                                                | Nominal Value                      | Unit              | Test Method             |
| Specific Gravity                                        | 1.16                               | g/cm <sup>3</sup> | ASTM D792               |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)               | 40 to 50                           | 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 <sup>1</sup> (Yield, 23°C)             | > 41.2                             | MPa               | ASTM D638               |
| Tensile Elongation <sup>2</sup> (Break, 23°C)           | > 18                               | %                 | ASTM D638               |
| Flexural Modulus <sup>3</sup> (23°C)                    | > 1770                             | MPa               | ASTM D790               |
| Flexural Strength <sup>4</sup> (23°C)                   | > 61.8                             | MPa               | ASTM D790               |
| Impact                                                  | Nominal Value                      | Unit              | Test Method             |
| Notched Izod Impact Strength <sup>5</sup>               | > 18                               | kJ/m <sup>2</sup> | 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 <sup>6</sup> |
| Flammability                                            | Nominal Value                      |                   | Test Method             |
| Flame Rating (3.20 mm)                                  | V-0                                |                   | UL 94                   |
| Injection                                               | Nominal Value                      | Unit              |                         |
| Drying Temperature                                      | 80.0 to 85.0                       | °C                |                         |
| Drying Time                                             | 2.0                                | hr                |                         |
| Suggested Max Moisture                                  | < 0.10                             | %                 |                         |

|                        |               |    |
|------------------------|---------------|----|
| Rear Temperature       | 160 to 170    | °C |
| Middle Temperature     | 170 to 190    | °C |
| Front Temperature      | 190 to 200    | °C |
| Nozzle Temperature     | 195 to 205    | °C |
| Processing (Melt) Temp | 210           | °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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