

Ghaed ABS ABS-80

Acrylonitrile Butadiene Styrene
Ghaed Basir Petrochemicals Co.

Message:

Classification: General purpose
Characteristic: Hi Flow, High rigidity
Application: Electronic and Electrical parts, vacuum cleaner, washing machine cover and Refrigerator door cap & etc

General Information			
Features	General Purpose		
	High Flow		
	High Rigidity		
Uses	Appliance Components		
	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)	45 to 55	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)	100 to 120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 23°C)	> 44.1	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C)	> 14	%	ASTM D638
Flexural Modulus ³ (23°C)	> 1960	MPa	ASTM D790
Flexural Strength ⁴ (23°C)	> 63.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁵	> 16	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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

