



PERSIAN GULF POLYMER

Acrylonitrile – Butadiene – Styrene ABS-80

Better Decision for better Production.

LDPE | LLDPE | MDPE | HDPE | PP | PVC | GPPS | HIPS | EPS | PET | **ABS** | SBR | PBR | PC

A. Classification:

General purpose, Hi Flow, High rigidity

B. Characteristic:

Electronic and Electrical parts, vacuum cleaner, washing machine cover and Refrigerator door cap & et.

C. DRYING:

It is recommended that ABS Resins be dried at (80-85°C) for 3 hours.

PRODUCT DATA SHEET:

PROPERTY	ABS-80 specification	UNIT	TEST METHOD
Izod impact (6.4 mm , notched)	16 - 20	Kj/m ²	D-256
Melt flow index (220°C , 10 kg)	45 - 55	gr/10 min	D-1238
Rock well hardness	100 - 120	R-scale	D-785
HDT (1.82 m pa)	82 - 85	°C	D-648
Vicat softening Temp (5kg/50°C)	93 - 95	°C	D-1525
Tensile strength (23°C , 50 mm/min)	450- 470	Kg/cm ²	D-638
Tensile elongation (23°C , 50 mm/min)	14 - 19	%	D-638
Flexural strength (23°C , 2.8 mm/min)	650 - 670	Kg/cm ²	D-790
Flexural Modulus (23°C , 2.8 mm/min)	20000 - 22000	Kg/cm ²	D-790
Specific Gravity (23°C)	1.04	D-792
Molding Shrinkage	0.4-0.7	%	D-955
Flammability (1/8inch(3.2mm))	HB	UI94

D. Typical properties:

These are not to be construed as specifications.

Some modifications may be required depending on the specific molding equipment and part configuration.

INJECTION MOLDING

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				

