

# ABS-70SR

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.

Property	Test method (ASTM)	Test condition	Unit	Typical value	ABS-70SR Specification
Izod impact	D-256	6.4 mm , notched	Kj/m <sup>2</sup>	27	MIN25
Melt flow index	D-1238	220°c , 10 kg	gr/10 min	10	7-14
Rock well hardness	D-785	.....	R-scale	112	100-120
HDT	D-648	1.82 m pa	°c	87	MIN82
Vicat softening Temp	D-1525	5kg/50°c	°c	97	MIN94
Tensile strength	D-638	23°c , 50 mm/min	Kg/cm <sup>2</sup>	470	MIN440
Tensile elongation	D-638	23°c , 50 mm/min	%	25	MIN16
Flexural strength	D-790	23°c , 2.8 mm/min	Kg/cm <sup>2</sup>	660	MIN630
Flexural Modulus	D-790	23°c , 2.8 mm/min	Kg/cm <sup>2</sup>	23000	MIN18000
Specific Gravity	D-792	23°c	..	1.04	1.04
Molding Shrinkage	D-955	...	%	0.4-0.7	0.4-0.7
Flammability	U194	1/8inch(3.2mm)	...	HB	HB

## TYPICAL ABS PROCESSING CONDITIONS

DRYING: it is recommended that GBPC ABS Resins be dried at (80-85°c)for 3 hours.

Extruder with one-stage or two-stage venting are recommended for extrusion of sheet. compression ratios should be between 2.5/1and3.0/1 for a single stage screw and L/D ratios 20/1 is typical.

Zone 1(°c)	Zone 2(°c)	Zone 3(°c)	Zone 4(°c)	Zone 5(°c)	Zone 6(°c)	Zone 7(°c)
190-200	190-200	200-210	200-210	210-220	210-220	210-220

Adapter(°c)	Die zone(°c)	Screen Pack Mesh (2layer)		
210-220	225-235	#60-80		