

Group	Grade	Characteristic	Application
Electroplating	ABS-10	General plating, Electroplating	Automobile parts, Electrical parts, Handles of automobile and refrigerator
High Gloss	HA-28WH	High gloss, anti-scratch	Electrical parts, home appliances, monitor, TV. Vacuum cleaner
	28WH	High gloss	Electrical parts, home appliances, monitor, TV. Vacuum cleaner
	HG-505	High gloss	Electrical parts, home appliances, monitor, TV. Vacuum cleaner

TYPICAL ABS PROCESSING CONDITIONS

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

The following molding conditions are recommended starting points for GBPC ABS Resin. A moisture level of $\leq 0.1\%$ should be reached before injection molding the resin.

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

Melt Temp (°C)	Nozzle Temp (°C)	Front Temp (°C)	Center Temp (°C)	Center Temp (°C)	Rear Temp(°C)
260	265-270	250-260	240-250	230-240	230-240
			Filling Speed	Mold Temp (°c)	
			Slow-Med	70-80	



Property	Test Method (ASTM)	Test Condition	Unit	ABS (special grade)			
				Electroplating	High Gloss		
				ABS-10	HA-28WH	28 WH	HG-505
Izod Impact	D - 256	6.4 mm, Notched	KJ/m ²	23	17	10	10
Melt Flow Index	D - 1238	220°C, 10 Kg	gr/10 min	30	30	30	30
Rockwell Hardness	D - 785	R-scale	Rockwell	104	110	112	115
Heat Deflection Temp	D - 648	0.45 Mpa	°C	86	91	94	95
Vical Softening Temp	D - 1525	10 N	°C	94	96	99	100
Tensile Strength	D - 638	23°C, 50 mm/min	Kg/cm ²	410	430	460	550
Tensile Elongation	D - 638	23°C, 50 mm/min	%	20	20	8	20
Flexural Strength	D - 790	23°C, 2.8 mm/min	Kg/cm ²	590	610	660	810
Flexural Modulus	D - 790	23°C, 2.8 mm/min	Kg/cm ²	18500	18000	21000	23000
Specific Gravity	D - 792	23°C	g/cm ³	1.04	1.04	1.04	1.04
Mold Shrinkage	D - 955	-	%	0.4 - 0.7	0.4 - 0.7	0.4 - 0.7	0.4 - 0.7
Flammability	UL 94	½ inch (3.2 mm)	-	HB	HB	HB	HB
Glossiness	D - 523	60	Glossity	88	88	90	94

Note 1) These are typical property values, not specifications.

Note 2) In pre-colored products, the values could slightly differ from table values.

Note 3) Values are measured at 23°C and in relative humidity (RH) of 50% on injection molded specimens of natural grade compliant with ASTM standards.