

Group	Grade	Characteristic	Application
Transparent	50-TR	Transparent	Home appliances, Electrical Parts, office supplies, washing machine
	GAC 550-TR	Transparent	Home appliances, Electrical Parts, office supplies, washing machine
High Heat	GH-500	Super high heat-resistant	Automobile and Electrical Parts

TYPICAL SAN PROCESSING CONDITIONS

DRYING: It is recommended that GBPC SAN 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 ≤0.1% should be reached before injection molding the resin.

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

INJECTION MOLDING

Melt Temp (°C)	Nozzle Temp (°C)	Front Temp (°C)	Center Temp (°C)	Center Temp (°C)	Rear Temp(°C)
230	215-225	210-220	210-220	200-210	190-200
			Filling Speed	Mold Temp (°c)	
			Slow-Med	60-80	



Property	Test Method (ASTM)	Test Condition	Unit	ABS (Special grade)		
				Transparent		High Heat
				GAC-550 TR	50-TR	GH-500
Izod Impact	D - 256	6.4 mm, Notched	KJ/m ²	14	12	16
Melt Flow Index	D - 1238	220°C , 10 Kg	gr/10 min	25	28	8
Rockwell Hardness	D - 785	R-scale	Rockwell	120	105	108
Heat Deflection Temp	D - 648	0.45 Mpa	°C	95	88	105
Vicat Softening Temp	D - 1525	10 N	°C	102	96	120
Tensile Strength	D - 638	23°C, 50 mm/min	Kg/cm ²	510	400	420
Tensile Elongation	D - 638	23°C, 50 mm/min	%	22	8	14
Flexural Strength	D - 790	23°C, 2.8 mm/min	Kg/cm ²	750	500	700
Flexural Modulus	D - 790	23°C, 2.8 mm/min	Kg/cm ²	18000	16000	19000
Specific Gravity	D - 792	23°C	g/cm ³	1.06	1.04	1.05
Molding Shrinkage	D - 955	-	%	0.3 - 0.6	0.4 - 0.7	0.4 - 0.7
Flammability	UL 94	½ inch (3.2 mm)	-	HB	HB	HB

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.