

■ Typical Property

Test Item	Test Condition	Unit	ASTM	RESULTS
Tensile Strength (引張強度)	23 °C	Kg/cm ²	D638	490
Tensile Elongation (伸 率)		%	D638	15
Flexural Strength (掘曲強度)	23 °C	Kg/cm ²	D790	700
Flexural Modulus (掘曲彈性率)	23 °C	Kg/cm ²	D790	24,000
Izod Impact Strength (衝擊強度)	3.2mm, Notched	Kg.cm/cm	D256	25
Rockwell Hardness (硬 度)	R scale		D785	110
Heat Distortion Temp. (熱變型溫度)	6.4mm, 18.6Kg/cm ² Unannealed	°C	D648	85
Melt flow Index (流動係數)	200 °C, 5.0Kg 230 °C, 3.8Kg 220 °C, 10Kg	g/10min	D1238	35
Molding Shrinkage (成型粹築率)		%	D755	0.5-0.8
Specific Gravity (比 重)			D792	1.04

*These are typical property values, not specifications.

*In case of colored products, the values could slightly differ by color.

■ Processing Information for ABS

Injection molding parameters	Nominal values
Drying Temperature	70 ~ 80 °C
Drying Time	2 ~ 3 hrs
Melt Temperature	220 ~ 240 °C
Nozzle Temperature	210 ~ 230 °C
Front Temperature	210 ~ 230 °C
Middle Temperature	210 ~ 230 °C
Rear Temperature	190 ~ 210 °C
Mold Temperature	40 ~ 60 °C
Injection Pressure	700 ~ 1200 Kg/cm ²
Holding Pressure	400 ~ 800 Kg/cm ²
Back Pressure	10 ~ 20 Kg/cm ²
Injection rate	5 ~ 10 seconds (Slow to moderate)
Screw speed	40 ~ 100 rpm
Suggested Max. Moisture	0.1 %
Suggested Max. Re grind	20 %

*The injection molding conditions vary according to the shape, type of the molding products and capacity of the injection molding machines.