



Kimia Baspar Golpa

PC/ABS165T

Non Reinforced Grade

General Information

● **Characteristic:** General purpose > Injection grade, Ultra high impact Resistance

● **Application:**

Automotive: Front Ends, Cluster pad main panel (instrument panel), Console Box, Glove Box Center, Wheel Cover.

Electrical: Monitor HSG, Fax HSG, Note book pc HSG, Cellular phone case, copy machine frame, connector, Switch

Industrial/Mechanical: Helmet Terminal Box, Electrical Tool HSG, Industrial Bobbin, Distributing Board Box, Gear and cams

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C	KJ/m2	55
Rock well hardness	ASTM D-785	R-Scal	Shore D	122
Tensile stress at yield	ASTM D638	23°c , 50 mm/min	Mpa	56
Tensile modulus			Mpa	2500
Elongation at Yield			%	4
Elongation at break			%	25
Flexural modulus	ASTM D790	23°c	Mpa	2700
Flexural strength			Mpa	75
Flammability				
Flammability	UL94	⅝ inch (3.2 mm)	HB	HB
Thermal Property				
HDT(Heat Deflection	ASTM D648	unannealed0.45MPa	°C	158
HDT(Heat Deflection	ASTM D648	unannealed1.82MPa	°C	108
Polymer property				
Melt flow index	ASTM D1238	220°c , 10kg	g/10min	30
Density	ASTMD792	23°c	g/cm3	1/12
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.5~0.7

1-The above data are typical values, they are only for material selection purpose, and variation within normal tolerances are for various colors.

typical values are not our specification and not be used for part or tool design.

2-all properties, except Melt Flow Index are measured on injection molded specimens and after 48 hour storage at 23°C and in RH of 50%..

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Processing guid (Injection molding condition)

Processing parameters	unit	value
Drying Temperature	°C	70~100
Drying Time	hrs	2~3
Moisture content	%	<0.1
Melt Temperature	°C	230~250
Cylinder Temperature	Reare	°C 230~250
	Middle	°C 230~250
	Front	°C 240~260
Nozzel Temperature	°C	240~260
Mold Temperature	°C	60~80
Back Pressure	kg/cm ²	150~500
Screw Speed	rpm	30~60

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

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