



# Kimia Baspar Golpa

**ABSH102**

**Heat Resistance**

## General Information

● **Characteristic:** General ABS > Heat Resistance grade

● **Application:** Mirror housings, Hair dryer shells, Electric oven exterior parts, Automobile parts  
Electronic and Electrical parts, and etc.

## Physical Property

| Property                | Test method | Test condition    | Unit           | Nominal Values |
|-------------------------|-------------|-------------------|----------------|----------------|
| Mechanical Property     |             |                   |                |                |
| Notched Izod impact     | ASTM D256   | 23°C              | KJ/m2          | 17             |
| Rock well hardness      | ASTM D-785  | R-Scal            | Shore D        | 110            |
| Tensile stress at yield | ASTM D638   | 23°C , 50 mm/min  | Mpa            | 42             |
| Tensile modulus         |             |                   | Mpa            | 2150           |
| Elongation at Yield     |             |                   | %              | 5              |
| Elongation at break     |             |                   | %              | 13             |
| Flexural modulus        | ASTM D790   | 23°C              | Mpa            | 2100           |
| Flexural strength       |             |                   | Mpa            | 65             |
| Flammability            |             |                   |                |                |
| Flammability            | UL94        | ⅜ inch (3.2 mm)   | HB (<76mm/min) | HB             |
| Thermal Property        |             |                   |                |                |
| HDT(Heat Deflection     | ASTM D648   | unannealed1.82MPa | °C             | 100            |
| Polymer property        |             |                   |                |                |
| Melt flow index         | ASTM D1238  | 220°C , 10kg      | g/10min        | 15             |
| Density                 | ASTMD792    | 23°C              | g/cm3          | 1/06           |
| 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%..

[www.kbgco.ir](http://www.kbgco.ir)



# Kimia Baspar Golpa

**ABSH102**

**Heat Resistance**

## Processing guid (Injection molding condition)

| Processing parameters | unit   | value      |
|-----------------------|--------|------------|
| Drying Temperature    | °C     | 80~100     |
| Drying Time           | hrs    | 3~4        |
| Moisture content      | %      | <0.1       |
| Melt Temperature      | °C     | 200~230    |
| Cylinder Temperature  | Reare  | °C 210~230 |
|                       | Middle | °C 210~230 |
|                       | Front  | °C 220~240 |
| Nozzel Temperature    | °C     | 220~240    |
| Mold Temperature      | °C     | 50~70      |
| Back Pressure         | kg/cm2 | 150~500    |
| Screw Speed           | rpm    | 30~60      |

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

[www.kbgco.ir](http://www.kbgco.ir)