

# ABS RESIN PROCESSING CONDITIONS

Items	General Purpose Grade	High Flow Grade	Metal Plating Grade	Heat Resistant Grade	Transparent Grade	Self Extinguishing Grade	Extrusion Grade
Grade No	AG1000 AG100H AG12A0 AG12A1 AG12A1-H AG12A3 AG12AJ(Black) ) AG15E0 AG15E1 AG15E1-H AG15E3 AG15A0 AG15A1 AG15A1-H AG15A2 AG15A3 AG15AB(Black) AG15AJ(Black) AG15AM AG15AS AG16A1(Healthcare)	AF3530 AF3535 AF3535-J(Black) AF3538B(Black) AF3538 AF3500 AF3560 AF3600	AG22AT AG23AT AG23AT-M AG26AT AG27AT	AX4000 AX4100 AX4300 AX400M(Heat Resistant Metal Plating Grade) AG20GF(Black) (ABS+20%Glass Fiber)	AT5500 AT5800	ANC100 ANC120 ANC150 ANC160 ANC180 ANC200 ANC180-B	AG10NP AG10AP AE8000 AE8000-H AE8200 AE8700 AG10NP-N AE10EP-J(Black)
Pre-drying (°C×hr)	70~80°C×2~3hr	70~80°C×2~3hr	70~80°C×2~3hr	90~95°C×2~3hr	70~80°C×2~3hr	70~80°C×2~3hr	70~80°C×2~3hr
Mold Shrinkage (%)	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Screw Temp. (°C)	190~230	180~230	190~230	200~250	190~230	160~200	180~230
Injection Pressure (Kg/cm <sup>2</sup> )	700~1100	600~1100	700~1100	700~1200	700~1100	600~1100	--
Mold Temp. (°C)	40~80	40~80	40~80	40~90	40~80	40~70	--
T-Die Temp. (°C)	--	--	--	--	--	--	190~230
Cooling Roll(°C)							
Upper							70~80
Middle							80~90
Lower	--	--	--	--	--	--	90~110

Remark : These data only a general information to the best of our knowledge. It can not be guaranteed due to variance of materials, conditions and equipments.



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