## ABS RESIN PROCESSING CONDITIONS

<table>
<thead>
<tr>
<th>Items</th>
<th>General Purpose Grade</th>
<th>High Flow Grade</th>
<th>Metal Plating Grade</th>
<th>Heat Resistant Grade</th>
<th>Transparent Grade</th>
<th>Self Extinguishing Grade</th>
<th>Extrusion Grade</th>
</tr>
</thead>
<tbody>
<tr>
<td>Grade No</td>
<td>AG1000</td>
<td>AF3530</td>
<td>AG22AT</td>
<td>AX4000</td>
<td>AT5500</td>
<td>ANC100</td>
<td>AG10NP</td>
</tr>
<tr>
<td></td>
<td>AG100H</td>
<td>AF3535</td>
<td>AG23AT</td>
<td>AX4100</td>
<td>AT5800</td>
<td>ANC120</td>
<td>AG10AP</td>
</tr>
<tr>
<td></td>
<td>AG12A0</td>
<td>AF3535-J(Black)</td>
<td>AG23AT-M</td>
<td>AX4300</td>
<td></td>
<td>ANC150</td>
<td>AE8000</td>
</tr>
<tr>
<td></td>
<td>AG12A1</td>
<td>AF3538B(Black)</td>
<td>AG26AT</td>
<td>AX400M(Heat Resistant Metal Plating Grade)</td>
<td></td>
<td>ANC160</td>
<td>AE8000-H</td>
</tr>
<tr>
<td></td>
<td>AG12A1-H</td>
<td>AF3538-H</td>
<td>AG27AT</td>
<td></td>
<td>AG20GF(Black) (ABS+20%Glass Fiber)</td>
<td></td>
<td>ANC180</td>
</tr>
<tr>
<td></td>
<td>AG12A3</td>
<td>AF3500</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>ANC200</td>
</tr>
<tr>
<td></td>
<td>AG12AJ(Black)</td>
<td>AF3560</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>ANC180-B</td>
</tr>
<tr>
<td></td>
<td>AG15E0</td>
<td>AF3600</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15E1</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15E1-H</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15E3</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15A0</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15A1</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15A2</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15A3</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15AB(Black)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15AJ(Black)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15AM</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG15AS</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>AG16A1(Healthcare)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Pre-drying (℃×hr)</td>
<td>70<del>80℃×2</del>3hr</td>
<td>70<del>80℃×2</del>3hr</td>
<td>70<del>80℃×2</del>3hr</td>
<td>70<del>95℃×2</del>3hr</td>
<td>70<del>80℃×2</del>3hr</td>
<td>70<del>80℃×2</del>3hr</td>
<td>70<del>80℃×2</del>3hr</td>
</tr>
<tr>
<td>Mold Shrinkage (%)</td>
<td>0.4~0.7</td>
<td>0.4~0.7</td>
<td>0.4~0.7</td>
<td>0.4~0.7</td>
<td>0.4~0.7</td>
<td>0.4~0.7</td>
<td>0.4~0.7</td>
</tr>
<tr>
<td>Screw Temp. (℃)</td>
<td>190~230</td>
<td>180~230</td>
<td>190~230</td>
<td>200~250</td>
<td>190~230</td>
<td>160~200</td>
<td>180~230</td>
</tr>
<tr>
<td>Injection Pressure (Kg/cm²)</td>
<td>700~1100</td>
<td>600~1100</td>
<td>700~1100</td>
<td>700~1200</td>
<td>700~1100</td>
<td>600~1100</td>
<td>--</td>
</tr>
<tr>
<td>Mold Temp. (℃)</td>
<td>40~80</td>
<td>40~80</td>
<td>40~80</td>
<td>40~90</td>
<td>40~80</td>
<td>40~70</td>
<td>--</td>
</tr>
<tr>
<td>T-Die Temp. (℃)</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
</tr>
<tr>
<td>Cooling Roll(℃)</td>
<td>Upper</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>70~80</td>
</tr>
<tr>
<td></td>
<td>Middle</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>80~90</td>
</tr>
<tr>
<td></td>
<td>Lower</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>90~110</td>
</tr>
</tbody>
</table>

**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.

**FORMOSA CHEMICALS & FIBRE CORPORATION PLASTICS DIVISION**

**HEAD OFFICE:** 201, TUNG HWA N. RD.,TAIPEI, TAIWAN, R.O.C.

**SERVICE TEL:** +886-2-27178405  **FAX:** +886-2-27131649