GAC 244

PC/ABS Alloy : Non Reinforced Grade

Classification: General purpose>Injection grade

Characteristic: Injection grade, high impact Resistance

Application: GAC 244 is an unreinforced PC/ABS alloy which offers good impact strength and high heat resistance. Especially, metal plating is very easy with GAC 244. So GAC 244 could be used outdoor housing which need metal plating such as, automotive door handle, lamp housing, etc

Property	Test method (ASTM)	Test condition	Unit	Typical value	GAC 244
Izod impact	D-256	6.4 mm , notched	Kj/m²	42	Min38
Melt flow index	D-1238	230°c , 21.6 kg	gr/10 min	38	35-45
Rock well hardness	D-785	.....	R-scale	100	90-110
HDT	D-648	1.82 m pa	°c	120	Min115
Tensile strength	D-638	23°c , 50 mm/min	Kg/cm²	460	Min450
Tensile elongation	D-638	23°c , 50 mm/min	%	100	Min90
Flexural strength	D-790	23°c , 2.8 mm/min	Kg/cm²	800	Min750
Flexural Modulus	D-790	23°c , 2.8 mm/min	Kg/cm²	20000	Min18000
Specific Gravity	D-792	23°c	..	1.08	1.08
Molding Shrinkage	D-955	…	%	0.5-0.7	0.5-0.7
Flammability	Ul94	1/8inch(3.2mm)	…	HB	HB

TYPICAL ABS PROCESSING CONDITIONS

The following molding conditions are recommended starting point for GBPC PC/ABS alloy. A moisture level of ≤0.1% should be reached before injection molding the resin.

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

DRYING: it is recommended that GBPC PC/ ABS Resins be dried at (80-95°c)for 3 hours.

INJECTION MOLDIN

Rear Temp(°c)	Center Temp (°c)	Center Temp (°c)	Front Temp (°c)	Nozzle Temp (°c)	Melt Temp (°c)
230-240	230-240	240-250	250-260	260-270	260

Mold Temp (°c)	Filling Speed			
70-80	Slow-Med			