

**Local name:** CAB 21HA-T2-UZ

**Grade:** GMW15581P  
ABS+PC T2

## Technical Data Sheet

**Type:** Injection molding, PC+ABS

**Application:** Interior, exterior trim

| Properties                     | Test Method | Unit               | Values    |
|--------------------------------|-------------|--------------------|-----------|
| <b>Physical properties</b>     |             |                    |           |
| Density                        | ISO 1183    | gm/cm <sup>3</sup> | 1.12±0.04 |
| Melt Mass Flow (260°C, 5kg)    | ISO 1133    | gm/10min           | Report    |
| Shrinkage (48h after molding)  | ISO 294     | %                  | ≥0.6      |
| <b>Mechanical properties</b>   |             |                    |           |
| Tensile Stress at yield        | ISO 527     | Mpa                | ≥45       |
| Tensile Modulus                | ISO 527-1   | Mpa                | ≥1800     |
| Nothched Charpy Impact (23°C)  | ISO 179-1   | kJ/m <sup>2</sup>  | ≥30       |
| Nothched Charpy Impact (-30°C) | ISO 179-1   | kJ/m <sup>2</sup>  | ≥15       |
| <b>Thermal properties</b>      |             |                    |           |
| Vicat softening                | ISO 306     | °C                 | ≥110      |
| HDT (1.8 MPa)                  | ISO 75      | °C                 | ≥88       |

## *Processing Guide (Injection Molding)*

| Processing Parameters    |        | Unit | Values    |
|--------------------------|--------|------|-----------|
| Drying Temperature       |        | °C   | 80        |
| Drying Time              |        | hrs  | 18-24     |
| Minimum Moisture Content |        | %    | 0.3       |
| Melt Temperature         |        | °C   | 230 ~ 260 |
| Cylinder Temperature     | Rear   | °C   | 200 ~ 210 |
|                          | Middle | °C   | 210 ~ 230 |
|                          | Front  | °C   | 225 ~ 250 |
| Nozzle Temperature       |        | °C   | 225~ 250  |
| Mold Temperature         |        | °C   | 50 ~ 95   |
| Back Pressure            |        | Bar  | 3.0 ~ 15  |