LG ABS MA201

LG Chem Ltd. - Acrylonitrile Butadiene Styrene

Friday, May 24, 2019

General Information

Product Description

Description

- General Purpose, Low Gloss

Application

- Automotive Sheet, Semi-Conductor Tray

General		
Material Status	• Commercial: Active	
Availability	• Asia Pacific • Europe	• Latin America • North America
Features	• General Purpose	• Low Gloss
Uses	• Automotive Applications	• Sheet
Processing Method	• Extrusion	• Injection Molding

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.04	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	7.3	g/10 min	
230°C/3.8 kg	0.20	g/10 min	
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.70	%	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2] (Yield, 3.20 mm)	49.0	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	37	%	ASTM D638
Flexural Modulus [3] (3.20 mm)	2400	MPa	ASTM D790
Flexural Strength [3] (3.20 mm)	73.5	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 6.40 mm)	250	J/m	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	108		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm	89.0	°C	
Vicat Softening Temperature	100	°C	ASTM D1525 [4]
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
1.5 mm	HB		
3.0 mm	HB		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	70 to 80	°C
Drying Time	3.0 to 4.0	hr

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Injection	Nominal Value	Unit
Rear Temperature	180 to 200	°C
Middle Temperature	190 to 210	°C
Front Temperature	200 to 230	°C
Nozzle Temperature	200 to 230	°C
Processing (Melt) Temp	200 to 230	°C
Mold Temperature	40 to 60	°C
Back Pressure	29.4 to 58.8	MPa
Screw Speed	30 to 60	rpm

Injection Notes

Minimum Moisture Content: 0.01%

Extrusion	Nominal Value	Unit
Drying Temperature	70 to 80	°C
Drying Time	3.0 to 4.0	hr
Cylinder Zone 1 Temp.	180 to 200	°C
Cylinder Zone 2 Temp.	190 to 210	°C
Cylinder Zone 3 Temp.	200 to 230	°C
Cylinder Zone 4 Temp.	200 to 230	°C
Adapter Temperature	200 to 230	°C
Melt Temperature	200 to 230	°C
Die Temperature	200 to 230	°C

Extrusion Notes

Minimum Moisture Content: 0.01%

Roll Stack Temperature, Top: 70 to 100°C
Roll Stack Temperature, Middle: 70 to 90°C
Roll Stack Temperature, Bottom: 60 to 90°C

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 50 mm/min

[3] 15 mm/min

[4] Rate A (50°C/h), Loading 2 (50 N)