

LG MABS XG569C

LG Chem Ltd. - Methyl Methacrylate / ABS

Friday, May 24, 2019

General Information

Product Description

Description

- Anti-Scratch, High Gloss

Application

- TV Front Cabinet, Bezel Audio/Video Housing

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • Latin America • North America
Features	• Good Scratch Resistance • High Gloss
Uses	• Electrical/Electronic Applications • Television Housings
RoHS Compliance	• RoHS Compliant
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity ²	1.10	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C, 3.20 mm, Injection Molded)	0.40 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ³ (23°C, 3.20 mm, Injection Molded)	2650	MPa	ASTM D638
Tensile Strength ³			ASTM D638
Yield, 23°C, 3.20 mm, Injection Molded	59.0	MPa	
Tensile Elongation ³			ASTM D638
Break, 23°C, 3.20 mm, Injection Molded	> 15	%	
Flexural Modulus ⁴ (23°C, 3.20 mm, Injection Molded)	2850	MPa	ASTM D790
Flexural Strength ⁴ (23°C, 3.20 mm, Injection Molded)	96.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm, Injection Molded	30	J/m	
-30°C, 6.40 mm, Injection Molded	30	J/m	
23°C, 3.20 mm, Injection Molded	100	J/m	
23°C, 6.40 mm, Injection Molded	100	J/m	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C, Injection Molded)	118		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵			ASTM D648
1.8 MPa, Unannealed, 6.40 mm, Injection Molded	84.0	°C	
Vicat Softening Temperature	92.0	°C	ASTM D1525 ⁶
RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746

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Thermal	Nominal Value	Unit	Test Method
RTI Str	50.0	°C	UL 746
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	80 to 90	°C
Drying Time	3.0 to 4.0	hr
Rear Temperature	180 to 200	°C
Middle Temperature	190 to 210	°C
Front Temperature	200 to 220	°C
Nozzle Temperature	200 to 230	°C
Processing (Melt) Temp	200 to 230	°C
Mold Temperature	40 to 60	°C
Back Pressure ⁷	2.94 to 5.88	MPa
Screw Speed	30 to 60	rpm

Injection Notes

Minimum Moisture Content: 0.01%

Notes

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

² 23°C

³ 50 mm/min

⁴ 15 mm/min

⁵ Edgewise

⁶ Rate A (50°C/h), Loading 2 (50 N)

⁷ Hydraulic Type