

LG ABS MP211

LG Chem Ltd. - Acrylonitrile Butadiene Styrene

Saturday, July 20, 2019

General Information

Product Description

Description

- High Flow Metal Plating ABS

Application

- Decorative Part (Home Appliance Door Handle)

General

Material Status	• Commercial: Active	
Availability	• Asia Pacific • Europe	• Latin America • North America
Features	• High Flow	• Platable
Uses	• Decorative Parts	• Handles
Processing Method	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity ²	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	27	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 Strength ³			ASTM D638
Yield, 23°C, 3.20 mm, Injection Molded	43.1	MPa	
Tensile Elongation ³			ASTM D638
Break, 23°C, 3.20 mm, Injection Molded	40	%	
Flexural Modulus ⁴ (23°C, 3.20 mm, Injection Molded)	2350	MPa	ASTM D790
Flexural Strength ⁴ (23°C, 3.20 mm, Injection Molded)	70.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm, Injection Molded	160	J/m	
-30°C, 6.40 mm, Injection Molded	150	J/m	
23°C, 3.20 mm, Injection Molded	340	J/m	
23°C, 6.40 mm, Injection Molded	300	J/m	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C, Injection Molded)	105		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm, Injection Molded	95.0	°C	
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm, Injection Molded	87.0	°C	
Vicat Softening Temperature	95.0	°C	ASTM D1525 ⁵
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI Str	60.0	°C	UL 746

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Flammability	Nominal Value	Unit	Test Method
Flame Rating		HB	UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	70 to 80	°C
Drying Time	3.0 to 4.0	hr
Rear Temperature	190 to 210	°C
Middle Temperature	200 to 220	°C
Front Temperature	210 to 230	°C
Nozzle Temperature	210 to 230	°C
Processing (Melt) Temp	210 to 230	°C
Mold Temperature	40 to 60	°C
Back Pressure	68.6 to 88.3	MPa
Screw Speed	< 80	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 Rate A (50°C/h), Loading 2 (50 N)