

LG ABS XR419

LG Chem Ltd. - Acrylonitrile Butadiene Styrene

Saturday, July 20, 2019

General Information

Product Description

Description

- Heat Resistance, Chemical Resistance

Applications

- Automotives Interior Housing (Ventgrille Etc)

General

Material Status	• Commercial: Active
Availability	<ul style="list-style-type: none"> • Asia Pacific • Europe • Latin America • North America
Features	<ul style="list-style-type: none"> • Chemical Resistant • Good Heat Resistance
Uses	<ul style="list-style-type: none"> • Automotive Interior Parts • Housings
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity ²	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.0	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	47.1	MPa	
Tensile Elongation ³			ASTM D638
Break, 23°C, 3.20 mm, Injection Molded	20	%	
Flexural Modulus ⁴ (23°C, 3.20 mm, Injection Molded)	2260	MPa	ASTM D790
Flexural Strength ⁴ (23°C, 3.20 mm, Injection Molded)	71.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm, Injection Molded	98	J/m	
-30°C, 6.40 mm, Injection Molded	88	J/m	
23°C, 3.20 mm, Injection Molded	250	J/m	
23°C, 6.40 mm, Injection Molded	230	J/m	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C, Injection Molded)	106		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm, Injection Molded	106	°C	
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm, Injection Molded	102	°C	
Vicat Softening Temperature	106	°C	ASTM D1525 ⁵

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Processing Information

Injection	Nominal Value	Unit
Drying Temperature	80 to 90	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	180 to 200	°C
Middle Temperature	200 to 220	°C
Front Temperature	220 to 230	°C
Nozzle Temperature	220 to 230	°C
Processing (Melt) Temp	220 to 250	°C
Mold Temperature	40 to 60	°C
Back Pressure	0.981 to 2.94	MPa

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)