

# LG ABS PI642G

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

## Message:

Description  
General Purpose, High Modulus  
Application  
Pipe Fitting

| General Information                             |               |                   |                         |
|-------------------------------------------------|---------------|-------------------|-------------------------|
| Uses                                            | Piping system |                   |                         |
| Processing Method                               | Extrusion     |                   |                         |
| Physical                                        | Nominal Value | Unit              | Test Method             |
| Specific Gravity                                | 1.04          | g/cm <sup>3</sup> | ASTM D792               |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)       | 8.0           | g/10 min          | ASTM D1238              |
| Molding Shrinkage - Flow (3.20 mm)              | 0.40 - 0.70   | %                 | ASTM D955               |
| Hardness                                        | Nominal Value | Unit              | Test Method             |
| Rockwell Hardness (R-Scale)                     | 110           |                   | ASTM D785               |
| Mechanical                                      | Nominal Value | Unit              | Test Method             |
| Tensile Strength <sup>1</sup> (Yield, 3.20 mm)  | 55.9          | MPa               | ASTM D638               |
| Tensile Elongation <sup>2</sup>                 |               |                   | ASTM D638               |
| Yield, 3.20mm                                   | > 5.0         | %                 | ASTM D638               |
| Fracture, 3.20mm                                | 30            | %                 | ASTM D638               |
| Flexural Modulus <sup>3</sup> (3.20 mm)         | 2750          | MPa               | ASTM D790               |
| Flexural Strength <sup>4</sup> (Yield, 3.20 mm) | 88.3          | MPa               | ASTM D790               |
| Impact                                          | Nominal Value | Unit              | Test Method             |
| Notched Izod Impact                             |               |                   | ASTM D256               |
| 23°C, 3.20 mm                                   | 260           | J/m               | ASTM D256               |
| 23°C, 6.40 mm                                   | 240           | J/m               | ASTM D256               |
| Thermal                                         | Nominal Value | Unit              | Test Method             |
| Deflection Temperature Under Load               |               |                   | ASTM D648               |
| 0.45 MPa, unannealed, 6.40mm <sup>5</sup>       | 92.0          | °C                | ASTM D648               |
| 0.45 MPa, unannealed, 6.40mm <sup>6</sup>       | 86.0          | °C                | ASTM D648               |
| Vicat Softening Temperature                     | 94.0          | °C                | ASTM D1525 <sup>7</sup> |
| Extrusion                                       | Nominal Value | Unit              |                         |
| Drying Temperature                              | 70.0 - 80.0   | °C                |                         |
| Drying Time                                     | 3.0 - 4.0     | hr                |                         |
| Suggested Max Moisture                          | < 0.010       | %                 |                         |
| Cylinder Zone 1 Temp.                           | 180 - 210     | °C                |                         |
| Cylinder Zone 2 Temp.                           | 190 - 230     | °C                |                         |

|                       |           |    |
|-----------------------|-----------|----|
| Cylinder Zone 3 Temp. | 200 - 250 | °C |
| Cylinder Zone 4 Temp. | 200 - 250 | °C |
| Adapter Temperature   | 200 - 250 | °C |
| Melt Temperature      | 200 - 250 | °C |
| Die Temperature       | 200 - 250 | °C |

#### Extrusion instructions

Top RollStack Temperature: 70 to 100°C Middle RollStack Temperature: 70 to 90°C Bottom RollStack Temperature: 60 to 90°C

#### NOTE

|    |                          |
|----|--------------------------|
| 1. | 50 mm/min                |
| 2. | 50 mm/min                |
| 3. | 15 mm/min                |
| 4. | 15 mm/min                |
| 5. | 4.6kg                    |
| 6. | 18.6kg                   |
| 7. | 速率 A (50°C/h), 载荷2 (50N) |

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

#### Recommended distributors for this material

## Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519  
 Phone: +86 13424755533  
 Email: sales@su-jiao.com  
 No. 215, Lianhe North Road, Fengxian District, Shanghai, China



WECHAT