

LG ABS XR418

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
High Heat, Low emission
Application
Automotives Interior parts

General Information			
Features	Low volatilization		
	Heat resistance, high		
Uses	Car interior parts		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	6.0	g/10 min	ISO 1133
shrinkage-Flow (3.20 mm)	0.40 - 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness	113		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2550	MPa	ISO 527-2/1
Tensile Stress (Yield)	48.0	MPa	ISO 527-2/50
Flexural Modulus ¹	2650	MPa	ISO 178
Flexural Stress ²	76.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	13	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	14	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ³			
0.45 MPa, unannealed, 4.00mm	107	°C	ISO 75-2/Be
1.8 MPa, not annealed, 4.00mm	90.0	°C	ISO 75-2/Ae
Vicat Softening Temperature	108	°C	ISO 306/B50
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 60°C	8.0E-5 - 9.0E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 60°C	8.0E-5 - 9.0E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	80 - 90	°C	
Drying Time	3.0 - 4.0	hr	

Suggested Max Moisture	0.050	%
Rear Temperature	180 - 210	°C
Middle Temperature	210 - 230	°C
Front Temperature	230 - 240	°C
Nozzle Temperature	230 - 240	°C
Processing (Melt) Temp	230 - 270	°C
Mold Temperature	40 - 60	°C
Back Pressure	0.981 - 2.94	MPa

NOTE

1. 2.0 mm/min
2. 2.0 mm/min
3. 120*10*4mm

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