

LG ABS XR410

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
High Heat, High Impact
Application
Automotives Interior & Exterior Housing

General Information			
Features	Impact resistance, high		
	Heat resistance, high		
Uses	Car interior parts		
	Automotive exterior parts		
	Shell		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	7.0	g/10 min	ISO 1133
shrinkage-Flow (3.20 mm)	0.40 - 0.80	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ISO 527-2/1
Tensile Stress (Yield)	50.0	MPa	ISO 527-2/50
Flexural Modulus ¹	2350	MPa	ISO 178
Flexural Stress ²	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	8.0	kJ/m ²	ISO 179/1eA
23°C	13	kJ/m ²	ISO 179/1eA
Notched Izod Impact			ISO 180/1A
-30°C	8.0	kJ/m ²	ISO 180/1A
23°C	15	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ³ (1.8 MPa, Unannealed, 4.00 mm)	86.0	°C	ISO 75-2/Ae
Vicat Softening Temperature	107	°C	ISO 306/B50
Flammability	Nominal Value		Test Method

Flame Rating	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	80 - 90	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.070	%
Rear Temperature	180 - 210	°C
Middle Temperature	210 - 230	°C
Front Temperature	230 - 240	°C
Nozzle Temperature	230 - 240	°C
Processing (Melt) Temp	230 - 260	°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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