

LG ABS SH625

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
High Impact, High Flow
Application
Ski Flat, Miscellaneous

General Information			
Features	Impact resistance, good		
	High liquidity		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	7.0	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)	85		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	34.3	MPa	ASTM D638
Tensile Elongation ²			ASTM D638
Yield, 3.20mm	> 5.0	%	ASTM D638
Fracture, 3.20mm	35	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	1810	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	53.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	540	J/m	ASTM D256
23°C, 6.40 mm	430	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm ⁵	90.0	°C	ASTM D648
0.45 MPa, unannealed, 6.40mm ⁶	83.0	°C	ASTM D648
Vicat Softening Temperature	90.0	°C	ASTM D1525 ⁷
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)

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