

LG Chemical America Inc

LG ABS HI-121

ABS

1/8/2003

Product text

Additional Properties:

Melt Flow Rate, ASTM D1238, 200°C/5kg: 1.5 g/10min

Melt Flow Rate, ASTM D1238, 230°C/3.8kg: 5.3 g/10min

Properties

General

Recycled Content	• No
Material Status	• Commercial: Active
Availability	• North America
Features	• Impact Resistance, Good
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Values	Test
Specific Gravity	1.05 -	ASTM D792
Melt Flow Rate	15 g/10 min	ASTM D1238
Melt Flow Condition	220°C/10.0 kg -	
Mold Shrink, Linear-Flow	4-7 mil/in	ASTM D955
Mechanical	Nominal Values	Test
Tensile Strength @ Yield	6800 psi	ASTM D638
Tensile Elongation @ Brk	25 %	ASTM D638
Flexural Modulus	327000 psi	ASTM D790
Flexural Strength	10700 psi	ASTM D790
Impact	Nominal Values	Test
Notched Izod Impact (High)	6.4 ft-lb/in	ASTM D256
Notched Izod Temperature	73 °F	
Notched Izod Thickness	0.125 in	
Hardness	Nominal Values	Test
Rockwell Hardness R	101 -	ASTM D785
Rockwell Scale	R-Scale -	
Thermal	Nominal Values	Test
DTUL @264psi - Unannealed	196 °F	ASTM D648
Vicat Softening Point	208 °F	ASTM D1525
Flammable	Nominal Values	Test
Flame Rating - UL, HB	0.0625 in	UL 94
Injection	Nominal Values	Test
Drying Temperature	175-195 °F	
Drying Time	2-3 h	
Rear Temperature	375-410 °F	
Middle Temperature	390-430 °F	

Front Temperature	410-445 °F
Nozzle Temperature	410-445 °F
Processing (Melt) Temp	430-465 °F
Mold Temperature	140-195 °F
Injection Pressure	9950-14200 psi
Back Pressure	0.0001-570 psi
Screw Speed	40-60 rpm

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