

# LG ABS MU620

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

## Message:

- Description
- Low Deformation
- Application
- Mock-Up

| General Information                             |               |                   |                         |
|-------------------------------------------------|---------------|-------------------|-------------------------|
| 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)       | 25            | 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)                     | 104           |                   | ASTM D785               |
| Mechanical                                      | Nominal Value | Unit              | Test Method             |
| Tensile Strength <sup>1</sup> (Yield, 3.20 mm)  | 37.3          | MPa               | ASTM D638               |
| Tensile Elongation <sup>2</sup>                 |               |                   | ASTM D638               |
| Yield, 3.20mm                                   | > 5.0         | %                 | ASTM D638               |
| Fracture, 3.20mm                                | 25            | %                 | ASTM D638               |
| Flexural Modulus <sup>3</sup> (3.20 mm)         | 2550          | MPa               | ASTM D790               |
| Flexural Strength <sup>4</sup> (Yield, 3.20 mm) | 68.6          | MPa               | ASTM D790               |
| Impact                                          | Nominal Value | Unit              | Test Method             |
| Notched Izod Impact                             |               |                   | ASTM D256               |
| 23°C, 3.20 mm                                   | 350           | J/m               | ASTM D256               |
| 23°C, 6.40 mm                                   | 310           | 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>       | 91.0          | °C                | ASTM D648               |
| 0.45 MPa, unannealed, 6.40mm <sup>6</sup>       | 84.0          | °C                | ASTM D648               |
| Vicat Softening Temperature                     | 92.0          | °C                | ASTM D1525 <sup>7</sup> |
| Flammability                                    | Nominal Value |                   | Test Method             |
| Flame Rating                                    | HB            |                   | UL 94                   |
| 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°CMiddle RollStack Temperature: 70 to 90°CBottom RollStack Temperature: 60 to90°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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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



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