

LG ABS AF365S

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
Flame Retardant, Heat resistant
Application
Electric parts, IT/OA device
TV, monitor housing

General Information			
UL YellowCard	E67171-100768102		
Features	Good Heat Resistance		
	Flame retardancy		
Uses	Electrical components		
	TV housing		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	7.5	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)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	2060	MPa	ASTM D638
Tensile Strength ² (Yield, 3.20 mm)	45.1	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield, 3.20mm	5.0	%	ASTM D638
Fracture, 3.20mm	> 15	%	ASTM D638
Flexural Modulus ⁴ (6.40 mm)	2450	MPa	ASTM D790
Flexural Strength ⁵ (6.40 mm)	73.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	78	J/m	ASTM D256
-30°C, 6.40 mm	69	J/m	ASTM D256
23°C, 3.20 mm	290	J/m	ASTM D256
23°C, 6.40 mm	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, unannealed, 6.40mm	92.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	88.0	°C	ASTM D648
Vicat Softening Temperature	93.0	°C	ASTM D1525 ⁶
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI	60.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.8 mm	V-1		UL 94
	V-0		
2.0 mm	5VB		UL 94
	V-0		
3.0 mm	5VA		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80 - 90	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	170 - 190	°C	
Middle Temperature	180 - 200	°C	
Front Temperature	190 - 210	°C	
Nozzle Temperature	200 - 230	°C	
Processing (Melt) Temp	200 - 230	°C	
Mold Temperature	40 - 60	°C	
Back Pressure	0.490 - 0.981	MPa	
Screw Speed	30 - 60	rpm	
Injection instructions			
Minimum Moisture Content: 0.01%			
NOTE			
1.	1.0 mm/min		
2.	50 mm/min		
3.	50 mm/min		
4.	15 mm/min		
5.	15 mm/min		
6.	速率 A (50°C/h), 载荷2 (50N)		

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