

LG ABS MA210

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
General Purpose, Low Gloss
Application
Automotive Sheet, Semi-Conductor Tray

General Information			
Features	Gloss, low		
Uses	Application in Automobile Field		
Processing Method	Extrusion		
	Injection molding		

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)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.70	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.19	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	47.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 60	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	70.6	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 3.20 mm	69	J/m	ASTM D256
-20°C, 6.40 mm	59	J/m	ASTM D256
23°C, 3.20 mm	98	J/m	ASTM D256
23°C, 6.40 mm	69	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	91.0	°C	ASTM D648
Vicat Softening Temperature	99.0	°C	ASTM D1525 ⁶

Flammability	Nominal Value	Test Method
Flame Rating		UL 94
0.800 mm	HB	UL 94
1.60 mm	HB	UL 94

2.50 mm	HB	UL 94
3.20 mm	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	70.0 - 80.0	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	< 0.010	%
Rear Temperature	180 - 200	°C
Middle Temperature	190 - 210	°C
Front Temperature	200 - 230	°C
Nozzle Temperature	200 - 230	°C
Processing (Melt) Temp	200 - 230	°C
Mold Temperature	40.0 - 60.0	°C
Back Pressure	29.4 - 58.8	MPa
Screw Speed	30 - 60	rpm
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 - 200	°C
Cylinder Zone 2 Temp.	190 - 210	°C
Cylinder Zone 3 Temp.	200 - 230	°C
Cylinder Zone 4 Temp.	200 - 230	°C
Adapter Temperature	200 - 230	°C
Melt Temperature	200 - 230	°C
Die Temperature	200 - 230	°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.	18.6kg	
6.	速率 A (50°C/h), 载荷2 (50N)	

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