

LG ABS XR404HJ

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
Heat Resistance, Curl Fit
Applications
Automotives Interior Housing (P/W Switch Housing Etc)

General Information			
Features	High Heat Resistance		
Uses	Automotive Applications		
	Automotive Exterior Parts		
	Housings		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	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 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	50.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	20	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2650	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	81.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	59	J/m	
-30°C, 6.40 mm	49	J/m	
23°C, 3.20 mm	160	J/m	
23°C, 6.40 mm	140	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	111	°C	
1.8 MPa, Unannealed, 6.40 mm	102	°C	
Vicat Softening Temperature	112	°C	ASTM D1525 ⁵
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	

Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	< 0.070	%
Rear Temperature	180 to 200	°C
Middle Temperature	200 to 220	°C
Front Temperature	220 to 230	°C
Nozzle Temperature	220 to 230	°C
Processing (Melt) Temp	190 to 210	°C
Mold Temperature	40.0 to 60.0	°C
Back Pressure	0.981 to 2.94	MPa

NOTE

- | | |
|----|-----------------------------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 15 mm/min |
| 4. | 15 mm/min |
| 5. | Rate A (50°C/h), Loading 2 (50 N) |

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