

Sindustris ABS LXG680

Acrylonitrile Butadiene Styrene

Sincerity Australia Pty Ltd.

Message:

Sindustris ABS LXG680 is an Acrylonitrile Butadiene Styrene (ABS) material. It is available in Asia Pacific for injection molding.

Important attributes of Sindustris ABS LXG680 are:

Flame Rated

High Flow

Impact Resistant

Scratch Resistant

Typical applications include:

Housings

Electrical/Electronic Applications

General Information			
Features	High Flow		
	High Impact Resistance		
	Scratch Resistant		
Uses	Electrical Housing		
	Housings		
	LCD Applications		
UL File Number	E306922		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	22	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.60	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	49.0	MPa	ASTM D638
Tensile Elongation ²			ASTM D638
Yield, 3.20 mm	> 6.0	%	
Break, 3.20 mm	30	%	
Flexural Modulus ³ (3.20 mm)	2890	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	82.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	98	J/m	

-30°C, 6.40 mm	98	J/m	
23°C, 3.20 mm	180	J/m	
23°C, 6.40 mm	180	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	91.0	°C	
0.45 MPa, Unannealed, 6.40 mm	91.0	°C	
1.8 MPa, Unannealed, 3.20 mm	87.0	°C	
1.8 MPa, Unannealed, 6.40 mm	87.0	°C	
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.60 mm	HB		
3.20 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.010	%	
Rear Temperature	170 to 190	°C	
Middle Temperature	180 to 200	°C	
Front Temperature	190 to 210	°C	
Nozzle Temperature	200 to 220	°C	
Processing (Melt) Temp	200 to 220	°C	
Mold Temperature	40.0 to 60.0	°C	
Back Pressure	29.4 to 58.8	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	15 mm/min		
4.	15 mm/min		

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