

LNP™ COLORCOMP™ MG94C compound

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

LNP* COLORCOMP* MG94C is a compound based on ABS. Added features of this grade include: superior flow, good impact. Good for use in thin-wall applications.
Also known as: LNP* COLORCOMP* Compound MG94
Product reorder name: MG94C

General Information			
UL YellowCard	E121562-102809592		
Features	Impact resistance, good		
	Good liquidity		
Uses	Thin wall parts		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.05	g/cm ³	ASTM D792
--	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
230°C/3.8 kg	12	g/10 min	ASTM D1238
220°C/10.0 kg	42	g/10 min	ISO 1133
220°C/5.0 kg	13	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.80	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	113		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2480	MPa	ASTM D638
--	2450	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	46.0	MPa	ASTM D638
Yield	46.0	MPa	ISO 527-2/50
Fracture ³	35.0	MPa	ASTM D638
Fracture	35.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	2.0	%	ASTM D638
Yield	2.3	%	ISO 527-2/50
Fracture ⁵	18	%	ASTM D638
Fracture	40	%	ISO 527-2/50

Flexural Modulus			
50.0mm span ⁶	2620	MPa	ASTM D790
-- ⁷	2500	MPa	ISO 178
Flexural Stress			
--	70.0	MPa	ISO 178
Yield, 50.0mm span ⁸	79.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	18	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	80	J/m	ASTM D256
23°C	240	J/m	ASTM D256
-30°C ¹⁰	7.0	kJ/m ²	ISO 180/1A
23°C ¹¹	16	kJ/m ²	ISO 180/1A
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	5.00	J	ASTM D3763
23°C, Total Energy	21.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	95.0	°C	ASTM D648
0.45 MPa, unannealed, 100 mm span ¹²	89.0	°C	ISO 75-2/Be
1.8 MPa, unannealed, 3.20mm	82.0	°C	ASTM D648
1.8 MPa, unannealed, 100 mm span ¹³	76.0	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	98.0	°C	ASTM D1525, ISO 306/B50 11 ¹⁴
--	100	°C	ISO 306/B120
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	8.8E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	8.5E-5	cm/cm/°C	ASTM E831, ISO 11359-2
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 (1.5 mm)	HB	UL 94	
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (240°C, 1000 sec ⁻¹)	173	Pa · s	ASTM D3835
Injection	Nominal Value	Unit	
Drying Temperature	82 - 88	°C	
Drying Time	2.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.10	%	
Suggested Shot Size	50 - 70	%	

Rear Temperature	188 - 199	°C
Middle Temperature	199 - 210	°C
Front Temperature	204 - 227	°C
Nozzle Temperature	204 - 246	°C
Processing (Melt) Temp	204 - 246	°C
Mold Temperature	49 - 71	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	30 - 60	rpm
Vent Depth	0.038 - 0.051	mm

NOTE

1.	5.0 mm/min
2.	Type 1, 5.0 mm/min
3.	Type 1, 5.0 mm/min
4.	Type 1, 5.0 mm/min
5.	Type 1, 5.0 mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4 sp=62mm
10.	80*10*4
11.	80*10*4
12.	120*10*4 mm
13.	120*10*4 mm
14.	标准 B (120°C/h), 载荷2 (50N)

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