

LG ABS XR474

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

- Description
- Heat Resistance
- Applications
- Automotives Interior & Exterior Housing

General Information			
UL YellowCard	E67171-248419		
Features	Heat resistance, high		
Uses	Car interior parts		
	Shell		
Processing Method	Injection molding		
Multi-Point Data	Specific Heat vs. Temperature (ISO 11403-2)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	113		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)	15	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	76.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	59	J/m	ASTM D256
-30°C, 6.40 mm	49	J/m	ASTM D256
23°C, 3.20 mm	140	J/m	ASTM D256
23°C, 6.40 mm	130	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm, injection molding	112	°C	ASTM D648
0.45 MPa, annealed, 6.40mm	120	°C	ASTM D648
Vicat Softening Temperature	122	°C	ASTM D1525 ⁵
RTI Elec (3.00 mm)	60.0	°C	UL 746

RTI Imp (3.00 mm)	60.0	°C	UL 746
RTI (3.00 mm)	60.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating (3.00 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	180 - 220	°C	
Middle Temperature	200 - 220	°C	
Front Temperature	220 - 230	°C	
Nozzle Temperature	220 - 230	°C	
Processing (Melt) Temp	190 - 210	°C	
Mold Temperature	40.0 - 60.0	°C	
Back Pressure	0.981 - 2.94	MPa	
Injection instructions			
Minimum Moisture Content: <0.07%			
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	15 mm/min		
4.	15 mm/min		
5.	速率 A (50°C/h), 载荷2 (50N)		

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