

LG ABS XR407E

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
Heat Resistance
Applicaition
Electric & Electronic Housing (MWO Frame, DVD inner part etc.)

General Information			
UL YellowCard	E67171-248414	E67171-317063	
Features	High Heat Resistance		
Uses	Electrical/Electronic Applications		
	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)	7.0	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)	45.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	20	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	74.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	78	J/m	
-30°C, 6.40 mm	69	J/m	
23°C, 3.20 mm	180	J/m	
23°C, 6.40 mm	170	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	113	°C	
1.8 MPa, Unannealed, 6.40 mm	105	°C	
Vicat Softening Temperature	114	°C	ASTM D1525 ⁵
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746

RTI Str	60.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
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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