

LG ABS PT270

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description:

Good Paintability

Application:

Exterior Part of Automobile and Motor cycle

General Information			
UL YellowCard	E67171-248391	E248280-462767	
Features	Sprayable		
Uses	Automotive exterior parts		
Forms	Particle		
Processing Method	Injection molding		
Multi-Point Data	Specific Heat vs. Temperature (ISO 11403-2)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.02 - 1.03	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	29	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	1660	MPa	ASTM D638
Tensile Strength ² (Yield, 3.20 mm)	39.2	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	> 10	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	2160	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	62.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	250	J/m	ASTM D256
-30°C, 6.40 mm	250	J/m	ASTM D256
23°C, 3.20 mm	390	J/m	ASTM D256
23°C, 6.40 mm	350	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	87.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	85.0	°C	ASTM D648
Vicat Softening Temperature	91.0	°C	ASTM D1525 ⁶
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	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	180 - 200	°C	
Middle Temperature	190 - 210	°C	
Front Temperature	200 - 220	°C	
Nozzle Temperature	200 - 230	°C	
Processing (Melt) Temp	210 - 240	°C	
Mold Temperature	40.0 - 70.0	°C	
Back Pressure	0.981 - 1.96	MPa	
Screw Speed	10 - 20	rpm	

Injection instructions

Minimum Moisture Content: 0.01%

NOTE

- 1.0 mm/min
- 50 mm/min
- 50 mm/min
- 15 mm/min
- 15 mm/min
- 速率 A (50°C/h), 载荷2 (50N)

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