

LG MABS TR580

Methyl Methacrylate / ABS

LG Chem Ltd.

Message:

Description
Transparency, chemical resistance
Application
medical products

General Information			
Features	Good chemical resistance		
	Definition, high		
Uses	Medical/nursing supplies		
Appearance	Clear/transparent		
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)	2.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	39.2	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	30	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	1770	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	63.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	78	J/m	ASTM D256
23°C, 6.40 mm	78	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	79.0	°C	ASTM D648
Optical	Nominal Value	Unit	Test Method
Transmittance	90.0	%	ASTM D1003
Haze	1.2	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	80 - 90	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	210 - 230	°C	
Middle Temperature	220 - 240	°C	
Front Temperature	230 - 250	°C	

Nozzle Temperature	230 - 260	°C
Processing (Melt) Temp	220 - 250	°C
Mold Temperature	50 - 70	°C
Back Pressure	29.4 - 58.8	MPa
Screw Speed	< 80	rpm

Injection instructions

Minimum Moisture Content: 0.01%

NOTE

1.	50 mm/min
2.	50 mm/min
3.	15 mm/min
4.	15 mm/min

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