

LG ABS LG713

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
Low Gloss, Extrusion
Application
Automotive Interior Housing (Cover Etc)

General Information			
Features	Gloss, low		
Uses	Application in Automobile Field		
	Car interior parts		
	Shell		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	4.0	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)	99		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	38.2	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	30	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	1860	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	56.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	110	J/m	ASTM D256
-30°C, 6.40 mm	98	J/m	ASTM D256
23°C, 3.20 mm	260	J/m	ASTM D256
23°C, 6.40 mm	240	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	97.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	90.0	°C	ASTM D648
Vicat Softening Temperature	95.0	°C	ASTM D1525 ⁵
Optical	Nominal Value		Test Method
Gloss (45°)	30		ASTM D2457

Extrusion	Nominal Value	Unit
Drying Temperature	70 - 80	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.050	%
Cylinder Zone 1 Temp.	180 - 210	°C
Cylinder Zone 2 Temp.	190 - 230	°C
Cylinder Zone 3 Temp.	200 - 250	°C
Cylinder Zone 4 Temp.	200 - 250	°C
Adapter Temperature	200 - 250	°C
Melt Temperature	200 - 260	°C
Die Temperature	200 - 250	°C

Extrusion instructions

Top Roll Stack Temperature: 70 to 100°C Middle Roll Stack Temperature: 70 to 90°C Bottom Roll Stack Temperature: 60 to 90°C

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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