

LG ABS LG709W

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
Low Gloss, Heat Resistance
Applications
Automotive Interior Housing (Sun-Visor Mirror Cover Etc)

General Information			
Features	High Heat Resistance		
	Low Gloss		
Uses	Automotive Applications		
	Automotive Interior Parts		
	Housings		
Processing Method	Injection Molding		
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)	3.0	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)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	43.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	15	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2160	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	69.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	59	J/m	
-30°C, 6.40 mm	49	J/m	
23°C, 3.20 mm	160	J/m	
23°C, 6.40 mm	140	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	114	°C	
1.8 MPa, Unannealed, 6.40 mm	106	°C	
Vicat Softening Temperature	114	°C	ASTM D1525 ⁵

Optical	Nominal Value	Test Method
Gloss (45°)	30	ASTM D2457

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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