

LG ABS BM662

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
Blow Molding, Heat Resistance
Application
Automotives Exterior Housing (Spoiler,Bumper Guard etc.)

General Information			
Features	Heat resistance, high		
Uses	Car anti-collision bar		
	Automotive exterior parts		
	Shell		
Processing Method	Blow 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)	5.0	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)	101		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)	15	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2160	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	71.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	88	J/m	ASTM D256
-30°C, 6.40 mm	78	J/m	ASTM D256
23°C, 3.20 mm	260	J/m	ASTM D256
23°C, 6.40 mm	250	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	103	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	97.0	°C	ASTM D648
Vicat Softening Temperature	104	°C	ASTM D1525
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	

Drying Time	3.0 - 4.0	hr
Cylinder Zone 1 Temp.	180 - 200	°C
Cylinder Zone 2 Temp.	190 - 210	°C
Cylinder Zone 3 Temp.	190 - 210	°C
Cylinder Zone 4 Temp.	200 - 220	°C
Adapter Temperature	220	°C
Melt Temperature	200 - 210	°C
Die Temperature	220	°C

Extrusion instructions

Processing information given is for Blow Molding. Minimum Moisture Content: 0.07%

NOTE

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

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