SolutionPartner

LG Chem

ABS AF365S

extrusion Molding Grade

Description

Flame Retardant, Heat resistant

Application

Electric parts, IT/OA device
TV, monitor housing

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.19
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.7
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	7.5
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm^2	450
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	5
@ Break	50mm/min		%	Min 20
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm^2	21,000
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm^2	750
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm^2	25,000
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	19
	-30℃		kg·cm/cm	7
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	28
	-30℃		kg·cm/cm	8
Rockwell Hardness	R-Scale	ASTM D785	-	108
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	89
	4.6kg		℃	95
Vicat Softening Temperature		ASTM D1525		
	5kg, 50℃/h		℃	96
	1kg, 120℃/h		℃	
Flammability		UL94		
1.7mm			class	V-1
2.0mm			class	V-0,5VB
3.0mm			class	V-0,5VA
Relative Temperature Index		UL 746B		
Electrical			℃	75 (1.8~3.0T)
Mechanical with Impact			℃	75 (1.8~3.0T)
Mechanical without Impact			℃	75(1.8~3.0T)

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection molulded specimens and after 48 hours storage at 23℃, 50% relative humidty.

Updated : 21-Dec-16

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	80 ~90
Drying Time		hrs	3 ~ 4
Minimum Moisture Content		%	0.01
Melt Temperature		℃	200 ~ 230
Cylinder Temperature	Rear	℃	170 ~ 190
	Middle	℃	180 ~ 200
	Front	℃	190 ~ 210
Nozzle Temperature		℃	200 ~ 230
Mold Temperature		℃	40 ~ 60
Back Pressure		kg/cm^2	5 ~ 10
Screw Speed		rpm	30 ~ 60

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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