

ABS LG704W

Injection Molding

Description

Low Gloss, Heat Resistance

Application

Automobiles Interior Housing
(Room Mirror Housing, Console Box Etc.)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.04
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.7
Melt Flow Rate	220 °C/10kg	ASTM D1238	g/10min	7
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	540
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	15
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm ²	860
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm ²	26,500
IZOD Impact Strength, 6.4mm (Notched)	23 °C	ASTM D256	kg-cm/cm	16
	-30 °C		kg-cm/cm	5
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg-cm/cm	18
	-30 °C		kg-cm/cm	6
Rockwell Hardness	R-Scale	ASTM D785	-	111
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	97
	4.6kg		°C	106
Vicat Softening Temperature	5kg, 50 °C/h	ASTM D1525	°C	106
Flammability		UL94		
Relative Temperature Index		UL 746B		
Electrical			°C	
Mechanical with Impact			°C	
Mechanical without Impact			°C	
Optical				
Gloss	45°	ASTM D2457	-	30.0

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 molded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	80 ~ 90
Drying Time		hrs	3 ~ 4
Recommendable Moisture Content		%	0.05 below
Melt Temperature		°C	220 ~ 250
Cylinder Temperature	Rear	°C	180 ~ 200
	Middle	°C	200 ~ 220
	Front	°C	220 ~ 230
Nozzle Temperature		°C	220 ~ 230
Mold Temperature		°C	40~60
Back Pressure		kg/cm ²	10 ~ 30
Measuring Speed		rpm	Low speed

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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