

# ABS LG713

Extrusion Molding

## Description

Low Gloss, Extrusion

## Application

Automotive Interior Housing (Cover Etc)

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
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	4
<b>Mechanical</b>				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm <sup>2</sup>	390
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	30
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm <sup>2</sup>	580
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm <sup>2</sup>	19,000
IZOD Impact Strength, 6.4mm (Notched)	23 °C	ASTM D256	kg-cm/cm	24
	-30 °C		kg-cm/cm	10
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg-cm/cm	27
	-30 °C		kg-cm/cm	11
Rockwell Hardness	R-Scale	ASTM D785	-	99
<b>Thermal</b>				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	90
	4.6kg		°C	97
Vicat Softening Temperature	5kg, 50 °C/h	ASTM D1525	°C	95
Flammability		UL94		
Relative Temperature Index		UL 746B		
Electrical			°C	
Mechanical with Impact			°C	
Mechanical without Impact			°C	
<b>Optical</b>				
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 (Extrusion Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	70 ~ 80	
Drying Time	hrs	3 ~ 4	
Recommendable Moisture Content	%	0.05 below	
Melt Temperature	°C	200 ~ 260	
Barrel Temperature	Zone 1	°C	180 ~ 210
	Zone 2	°C	190 ~ 230
	Zone 3	°C	200 ~ 250
	Zone 4	°C	200 ~ 250
Adapter Temperature	°C	200 ~ 250	
Die Temperature	°C	200 ~ 250	
Roll Stack Temperature	Top	°C	70 ~ 100
	Middle	°C	70 ~ 90
	Bottom	°C	60 ~ 90

Note) Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.

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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