SolutionPartner

LG Chem

MABS TR580

Injection Molding

Description

Transparency, chemical resistance

Application

medical products

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.06
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	2.5
Molding Shrinkage		ASTM D955	%	0.4 ~ 0.7
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm^2	380
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	35
Flexural Strenghth, 3.2mm	15mm/min	ASTM D790	kg/cm^2	600
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm^2	18,000
IZOD Impact Strehgth, 6.4mm (Notched)	23℃	ASTM D256	kg·cm/cm	8
IZOD Impact Strehgth, 3.2mm (Notched)	23℃	ASTM D256	kg·cm/cm	8
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	℃	79
Optical				
Haze		ASTM D1003	%	1.8
Transparency		ASTM D1003	%	89

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-Jun-17

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Processing Guide(Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	80~90
Drying Time		hrs	2 ~ 4
Maximum Moisture Content		%	0.1
Melt Temperature		℃	220 ~ 250
Cylinder Temperature	Rear	℃	210 ~ 230
	Middle	℃	220 ~ 240
	Front	℃	230 ~ 250
Nozzle Temperature		℃	230 ~ 260
Mold Temperature		℃	50 ~ 70
Back Pressure		kg/cm^2	300 ~ 600
Screw Speed		rpm	under 80

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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