

MABS XG568

Injection Molding

Description

Anti-Scratch, High Gloss

Application

TV Front Cabinet, Bezel

Audio/Video Housing

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.1
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	18
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	540
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	35
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm ²	880
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm ²	28,000
IZOD Impact Strength, 6.4mm (Notched)	23℃	ASTM D256	kg·cm/cm	11
IZOD Impact Strength, 3.2mm (Notched)	23℃	ASTM D256	kg·cm/cm	8
Rockwell Hardness	R-Scale	ASTM D785	-	115
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	℃ ℃	82
Flammability 1.6mm 3.2mm		UL94	class class	HB HB
Others				
Ozone Resistance	5sec	JIS K6301	-	No Crack

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℃, 50% relative humidity.

Updated : 21-Jun-17

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	80 ~ 90	
Drying Time	hrs	3 ~ 4	
Maximum Moisture Content	%	0.1	
Melt Temperature	°C	200 ~ 230	
Cylinder Temperature	Rear	°C	180 ~ 200
	Middle	°C	190 ~ 210
	Front	°C	200 ~ 220
Nozzle Temperature	°C	200 ~ 230	
Mold Temperature	°C	40 ~ 60	
Back Pressure	kg/cm ²	300 ~ 600	
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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