

**ABS ER460**

ABS

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	23	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0055	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Modulus	2158	MPa	ASTM D 638
Tensile Strength at Yield	48.1	MPa	ASTM D 638
Elongation at Break	50	%	ASTM D 638
Flexural Modulus	2551	MPa	ASTM D 790
Flexural Strength	78.5	MPa	ASTM D 790
Rockwell Hardness	R 108	-	ASTM D 785
Izod Impact notched, 1/8 in	236	J/m	ASTM D 256
Izod Impact notched, 1/4 in	236	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	113	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
DTUL @ 66 psi	96	°C	ASTM D 648
DTUL @ 264 psi	91	°C	ASTM D 648
Vicat Temperature	97	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1050	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	210 - 240	°C	-
Mold temperature	40 - 70	°C	-
Zone 1	180 - 200	°C	-
Zone 2	190 - 210	°C	-
Zone 3	200 - 220	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	30 - 60	MPa	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

Heat stabilized or stable to heat

**Applications**

Automotive, Electrical and Electronical

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America