

**ABS HF380P**

ABS

LG Chem

| Processing/Physical Characteristics | Value         | Unit    | Test Standard |
|-------------------------------------|---------------|---------|---------------|
| <b>ASTM Data</b>                    |               |         |               |
| Melt Flow Index, MFI                | <b>53</b>     | g/10min | ASTM D 1238   |
| Temperature                         | <b>220</b>    | °C      | -             |
| Load                                | <b>10</b>     | kg      | -             |
| Mold Shrinkage, MD                  | <b>0.0055</b> | mm/mm   | ASTM D 955    |

| Mechanical properties       | Value        | Unit | Test Standard |
|-----------------------------|--------------|------|---------------|
| <b>ASTM Data</b>            |              |      |               |
| Tensile Strength at Yield   | <b>43.2</b>  | MPa  | ASTM D 638    |
| Elongation at Break         | <b>40</b>    | %    | ASTM D 638    |
| Flexural Modulus            | <b>2453</b>  | MPa  | ASTM D 790    |
| Flexural Strength           | <b>69.7</b>  | MPa  | ASTM D 790    |
| Rockwell Hardness           | <b>R 108</b> | -    | ASTM D 785    |
| Izod Impact notched, 1/8 in | <b>196</b>   | J/m  | ASTM D 256    |
| Izod Impact notched, 1/4 in | <b>196</b>   | J/m  | ASTM D 256    |

| Thermal properties | Value     | Unit | Test Standard |
|--------------------|-----------|------|---------------|
| <b>ASTM Data</b>   |           |      |               |
| UL 94 Flame rating | <b>HB</b> | -    | UL 94         |
| DTUL @ 264 psi     | <b>85</b> | °C   | ASTM D 648    |

| Other properties | Value       | Unit              | Test Standard |
|------------------|-------------|-------------------|---------------|
| Density          | <b>1040</b> | kg/m <sup>3</sup> | ASTM D 792    |

| Processing Recommendation Injection Molding | Value            | Unit | Test Standard |
|---|------------------|------|---------------|
| Pre-drying - Temperature                    | <b>80</b>        | °C   | -             |
| Pre-drying - Time                           | <b>2 - 4</b>     | h    | -             |
| Processing humidity                         | <b>≤0.01</b>     | %    | -             |
| Melt temperature                            | <b>210 - 240</b> | °C   | -             |
| Mold temperature                            | <b>40 - 70</b>   | °C   | -             |
| Zone 1                                      | <b>180 - 200</b> | °C   | -             |
| Zone 2                                      | <b>190 - 210</b> | °C   | -             |
| Zone 3                                      | <b>200 - 220</b> | °C   | -             |
| Nozzle temperature                          | <b>200 - 230</b> | °C   | -             |
| Screw speed                                 | <b>30 - 60</b>   | rpm  | -             |
| Back pressure                               | <b>30 - 60</b>   | MPa  | -             |

**Characteristics****Processing**

Injection Molding

**Applications**

Electrical and Electronical

**Regional Availability**

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