

ABS HF380U

ABS

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	43	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0055	mm/mm	ASTM D 955
Mechanical properties			
ASTM Data			
Tensile Modulus	2148	MPa	ASTM D 638
Tensile Strength at Yield	44.1	MPa	ASTM D 638
Elongation at Break	40	%	ASTM D 638
Flexural Modulus	2403	MPa	ASTM D 790
Flexural Strength	70.6	MPa	ASTM D 790
Rockwell Hardness	R 106	-	ASTM D 785
Izod Impact notched, 1/8 in	265	J/m	ASTM D 256
Izod Impact notched, 1/4 in	245	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	118	J/m	ASTM D 256
Temperature	-30	°C	-
Thermal properties			
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
DTUL @ 66 psi	89	°C	ASTM D 648
DTUL @ 264 psi	86	°C	ASTM D 648
Vicat Temperature	94	°C	ASTM D 1525
Electrical properties			
ISO Data			
Comparative tracking index	500	-	IEC 60112
Other properties			
Density	1040	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
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	-
Nozzle temperature	200 - 230	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	30 - 60	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Electrical and Electronical

Special Characteristics

U.V. stabilized or stable to weather

Regional Availability

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