

ABS HI121U

ABS

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	22	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
ASTM Data			
Tensile Strength at Yield	46.1	MPa	ASTM D 638
Elongation at Break	30	%	ASTM D 638
Flexural Modulus	2600	MPa	ASTM D 790
Flexural Strength	75.5	MPa	ASTM D 790
Rockwell Hardness	R 107	-	ASTM D 785
Izod Impact notched, 1/4 in	283	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
DTUL @ 264 psi	87	°C	ASTM D 648

Electrical properties	Value	Unit	Test Standard
ISO Data			
Comparative tracking index	600	-	IEC 60112

Other properties	Value	Unit	Test Standard
Density	1040	kg/m ³	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	-
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