

**ABS MU620**

ABS

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>25</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>37.3</b>	MPa	ASTM D 638
Elongation at Yield	<b>5</b>	%	ASTM D 638
Elongation at Break	<b>25</b>	%	ASTM D 638
Flexural Modulus	<b>2551</b>	MPa	ASTM D 790
Flexural Strength	<b>68.7</b>	MPa	ASTM D 790
Rockwell Hardness	<b>R 104</b>	-	ASTM D 785
Izod Impact notched, 1/8 in	<b>339</b>	J/m	ASTM D 256
Izod Impact notched, 1/4 in	<b>302</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 @ 66 psi	<b>91</b>	°C	ASTM D 648
DTUL @ 264 psi	<b>84</b>	°C	ASTM D 648
Vicat Temperature	<b>92</b>	°C	ASTM D 1525

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

Processing Recommendation Extrusion	Value	Unit	Test Standard
Pre-drying - Temperature	<b>70 - 80</b>	°C	-
Pre-drying - Time	<b>3 - 4</b>	h	-
Processing humidity	<b>≤0.01</b>	%	-
Melt temperature	<b>200 - 250</b>	°C	-
Zone 1	<b>180 - 210</b>	°C	-
Zone 2	<b>190 - 230</b>	°C	-
Zone 3	<b>200 - 250</b>	°C	-
Zone 4	<b>200 - 250</b>	°C	-
Nozzle temperature	<b>200 - 250</b>	°C	-

**Characteristics****Processing**

Other Extrusion

**Regional Availability**

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