

ABS AF365

ABS

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	30	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 Modulus	2060	MPa	ASTM D 638
Tensile Strength at Yield	44.1	MPa	ASTM D 638
Elongation at Yield	5	%	ASTM D 638
Elongation at Break	20	%	ASTM D 638
Flexural Modulus	2551	MPa	ASTM D 790
Flexural Strength	73.6	MPa	ASTM D 790
Rockwell Hardness	R 108	-	ASTM D 785
Izod Impact notched, 1/8 in	235	J/m	ASTM D 256
Izod Impact notched, 1/4 in	177	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	78.5	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	2.0	mm	-
Burning behav. 5V at thickness h	5VB	class	IEC 60695-11-20
Thickness tested	2.0	mm	-
ASTM Data			
UL 94 Flame rating	V-1	-	UL 94
Thickness tested	1.7	mm	-
DTUL @ 66 psi	92 ⁽¹⁾	°C	ASTM D 648
DTUL @ 264 psi	86 ⁽¹⁾	°C	ASTM D 648
Vicat Temperature	93	°C	ASTM D 1525

1: 6.4 mm

Other properties	Value	Unit	Test Standard
Density	1190	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	200 - 230	°C	-
Mold temperature	40 - 60	°C	-
Zone 1	170 - 190	°C	-
Zone 2	180 - 200	°C	-
Zone 3	190 - 210	°C	-
Nozzle temperature	200 - 230	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.5 - 1	MPa	-

Characteristics**Processing**

Injection Molding

Applications

IT / Business Machine, Electrical and Electronical

Special Characteristics

Flame retardant, Heat stabilized or stable to heat

Regional Availability

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