ABS ER400-M

ABS LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**12**	g/10min	ISO 1133
Temperature	**220**	°C	-
Load	**10**	kg	-
Molding shrinkage, parallel	**0.6**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2000**	MPa	ISO 527
Yield stress	**40**	MPa	ISO 527
Flexural modulus, 23°C	**2100**	MPa	ISO 178
Flexural strength	**60**	MPa	ISO 178
Charpy notched impact strength, +23°C	**18**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**18**	kJ/m²	ISO 180/1A
Rockwell hardness	**R 99**	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**83**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**97**	°C	ISO 75-1/-2
Vicat softening temperature, B	**99**	°C	ISO 306
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10

Other properties	Value	Unit	Test Standard
Density	**1040**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80 - 90**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Processing humidity	**≤0.07**	%	-
Melt temperature	**230 - 260**	°C	-
Mold temperature	**40 - 60**	°C	-
Zone 1	**180 - 210**	°C	-
Zone 2	**210 - 230**	°C	-
Zone 3	**230 - 240**	°C	-
Nozzle temperature	**230 - 240**	°C	-
Back pressure	**1 - 3**	MPa	-

Characteristics

Processing

Injection Molding, Other Extrusion

Regional Availability

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

Applications

Automotive