

**ABS HI121**

ABS

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	21	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	21	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
<b>ISO Data</b>			
Yield stress	46	MPa	ISO 527
Strain at break	10	%	ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	63	MPa	ISO 178
Charpy notched impact strength, +23°C	30 <sup>[1]</sup>	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	10 <sup>[1]</sup>	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	28 <sup>[1]</sup>	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	10 <sup>[1]</sup>	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
Rockwell hardness	R 107	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Strength at Yield	45	MPa	ASTM D 638
Elongation at Break	10	%	ASTM D 638
Flexural Modulus	2450	MPa	ASTM D 790
Flexural Strength	73	MPa	ASTM D 790
Rockwell Hardness	R 106	-	ASTM D 785
Izod Impact notched, 1/8 in	340	J/m	ASTM D 256
Izod Impact notched, 1/4 in	320	J/m	ASTM D 256

1: 4 mm

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	75 <sup>[2]</sup>	°C	ISO 75-1/-2
Vicat softening temperature, B	93	°C	ISO 306
<b>ASTM Data</b>			
DTUL @ 264 psi	85 <sup>[3]</sup>	°C	ASTM D 648
Vicat Temperature	93	°C	ASTM D 1525

2: 4 mm 3: 6.4 mm

Other properties	Value	Unit	Test Standard
Density	1040	kg/m <sup>3</sup>	ISO 1183
Density	1040	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	70 - 80	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	200 - 250	°C	-
Mold temperature	40 - 80	°C	-
Screw speed	30 - 60	rpm	-

**Characteristics**

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**Processing**

Injection Molding, Pipe/Tube Extrusion

**Applications**

Electrical and Electronical

**Special Characteristics**

High impact or impact modified

**Regional Availability**

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