ABS MA201

ABS LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	**7**	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	**51**	MPa	ASTM D 638
Elongation at Break	**30**	%	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	**377**	J/m	ASTM D 256
Izod Impact notched, 1/4 in	**245**	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	**179**	J/m	ASTM D 256
Temperature	**-20**	°C	-

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	**HB**	-	UL 94
Thickness tested	**0.8**	mm	-
DTUL @ 264 psi	**92**	°C	ASTM D 648
Vicat Temperature	**100**	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	**0.19**	%	ASTM D 570
Density	**1040**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**70 - 80**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Processing humidity	**≤0.01**	%	-
Melt temperature	**200 - 230**	°C	-
Mold temperature	**40 - 60**	°C	-
Zone 1	**180 - 200**	°C	-
Zone 2	**190 - 210**	°C	-
Zone 3	**200 - 230**	°C	-
Nozzle temperature	**200 - 230**	°C	-
Screw speed	**30 - 60**	rpm	-
Back pressure	**30 - 60**	MPa	-

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

Characteristics

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Processing

Injection Molding, Other Extrusion

Regional Availability

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

Applications

Automotive, General Purpose