

ABS MA221

ABS

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	5	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	42.2	MPa	ASTM D 638
Elongation at Break	50	%	ASTM D 638
Flexural Modulus	2158	MPa	ASTM D 790
Flexural Strength	60.8	MPa	ASTM D 790
Rockwell Hardness	R 100	-	ASTM D 785
Izod Impact notched, 1/8 in	547	J/m	ASTM D 256
Izod Impact notched, 1/4 in	302	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	283	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	90	°C	ASTM D 648
Vicat Temperature	98	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.19	%	ASTM D 570
Density	1040	kg/m ³	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

Applications

Automotive

Special Characteristics

High impact or impact modified

Regional Availability

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