

ABS PI642G

ABS

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	8	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	55.9	MPa	ASTM D 638
Elongation at Yield	5	%	ASTM D 638
Elongation at Break	30	%	ASTM D 638
Flexural Modulus	2747	MPa	ASTM D 790
Flexural Strength	88.3	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785
Izod Impact notched, 1/8 in	254	J/m	ASTM D 256
Izod Impact notched, 1/4 in	226	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	92	°C	ASTM D 648
DTUL @ 264 psi	86	°C	ASTM D 648
Vicat Temperature	94	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1040	kg/m ³	ASTM D 792

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 - 250	°C	-
Zone 1	180 - 210	°C	-
Zone 2	190 - 230	°C	-
Zone 3	200 - 250	°C	-
Zone 4	200 - 250	°C	-
Nozzle temperature	200 - 250	°C	-

Characteristics**Processing**

Pipe/Tube Extrusion, Other Extrusion

Regional Availability

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

Applications

General Purpose