

**ABS XR409H**

ABS

LG Chem

| Processing/Physical Characteristics | Value  | Unit    | Test Standard |
|-------------------------------------|--------|---------|---------------|
| <b>ASTM Data</b>                    |        |         |               |
| Melt Flow Index, MFI                | 3      | 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>ASTM Data</b>                     |       |      |               |
| Tensile Strength at Yield            | 47.1  | MPa  | ASTM D 638    |
| Elongation at Break                  | 20    | %    | ASTM D 638    |
| Flexural Modulus                     | 2354  | 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          | 151   | J/m  | ASTM D 256    |
| Izod Impact notched, 1/4 in          | 141   | J/m  | ASTM D 256    |
| Izod Impact notched, Low-Temperature | 75.4  | J/m  | ASTM D 256    |
| Temperature                          | -30   | °C   | -             |

| Thermal properties | Value | Unit | Test Standard |
|--------------------|-------|------|---------------|
| <b>ASTM Data</b>   |       |      |               |
| UL 94 Flame rating | HB    | -    | UL 94         |
| DTUL @ 66 psi      | 116   | °C   | ASTM D 648    |
| DTUL @ 264 psi     | 105   | °C   | ASTM D 648    |
| Vicat Temperature  | 114   | °C   | ASTM D 1525   |

| Electrical properties           | Value | Unit   | Test Standard |
|---------------------------------|-------|--------|---------------|
| <b>ISO Data</b>                 |       |        |               |
| Comparative tracking index      | 600   | -      | IEC 60112     |
| <b>ASTM Data</b>                |       |        |               |
| Dielectric Strength, Short Time | 33    | kV/mm  | ASTM D 149    |
| Volume Resistivity              | 1500  | Ohm*cm | ASTM D 257    |

| Other properties | Value | Unit              | Test Standard |
|------------------|-------|-------------------|---------------|
| Density          | 1060  | kg/m <sup>3</sup> | ASTM D 792    |

| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature                    | 80 - 90   | °C   | -             |
| Pre-drying - Time                           | 3 - 4     | h    | -             |
| Processing humidity                         | ≤0.01     | %    | -             |
| Melt temperature                            | 230 - 250 | °C   | -             |
| Mold temperature                            | 60 - 80   | °C   | -             |
| Zone 1                                      | 180 - 220 | °C   | -             |
| Zone 2                                      | 220 - 240 | °C   | -             |
| Zone 3                                      | 230 - 250 | °C   | -             |
| Nozzle temperature                          | 240 - 250 | °C   | -             |
| Screw speed                                 | 50 - 100  | rpm  | -             |
| Back pressure                               | 30 - 60   | MPa  | -             |

**Characteristics****Processing**

Injection Molding

**Applications**

Automotive

**Special Characteristics**

Heat stabilized or stable to heat

**Regional Availability**

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