

**ABS XR409HJ**

ABS

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>5</b>	g/10min	ASTM D 1238
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
Mold Shrinkage, MD	<b>0.0055</b>	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength at Yield	<b>47.1</b>	MPa	ASTM D 638
Elongation at Break	<b>20</b>	%	ASTM D 638
Flexural Modulus	<b>2453</b>	MPa	ASTM D 790
Flexural Strength	<b>77.5</b>	MPa	ASTM D 790
Rockwell Hardness	<b>R 105</b>	-	ASTM D 785
Izod Impact notched, 1/8 in	<b>123</b>	J/m	ASTM D 256
Izod Impact notched, 1/4 in	<b>113</b>	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	<b>66</b>	J/m	ASTM D 256
Temperature	<b>-30</b>	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	<b>HB</b>	-	UL 94
DTUL @ 66 psi	<b>114</b>	°C	ASTM D 648
DTUL @ 264 psi	<b>105</b>	°C	ASTM D 648
Vicat Temperature	<b>112</b>	°C	ASTM D 1525

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

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>80 - 90</b>	°C	-
Pre-drying - Time	<b>3 - 4</b>	h	-
Processing humidity	<b>≤0.01</b>	%	-
Melt temperature	<b>220 - 240</b>	°C	-
Mold temperature	<b>60 - 80</b>	°C	-
Zone 1	<b>180 - 210</b>	°C	-
Zone 2	<b>220 - 230</b>	°C	-
Zone 3	<b>230 - 240</b>	°C	-
Nozzle temperature	<b>230 - 240</b>	°C	-
Screw speed	<b>50 - 100</b>	rpm	-
Back pressure	<b>30 - 60</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

Heat stabilized or stable to heat

**Applications**

Automotive

**Regional Availability**

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