ABS XR410

ABS LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**7**	cm³/10min	ISO 1133
Temperature	**220**	°C	-
Load	**10**	kg	-
Molding shrinkage, parallel	**0.6**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2300**	MPa	ISO 527
Yield stress	**50**	MPa	ISO 527
Strain at break	**10**	%	ISO 527
Flexural modulus, 23°C	**2350**	MPa	ISO 178
Flexural strength	**70**	MPa	ISO 178
Charpy notched impact strength, +23°C	**13**[1]	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**8**[1]	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**15**[1]	kJ/m²	ISO 180/1A
Izod notched impact strength	**8**[1]	kJ/m²	ISO 180/1A
Temperature	**-30**	°C	-
Rockwell hardness	**R 110**	-	ISO 2039-2

1: 4 mm

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**86**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**94**	°C	ISO 75-1/-2
Vicat softening temperature, B	**107**	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	**HB**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10
Thickness tested	**3.0**	mm	-

Other properties	Value	Unit	Test Standard
Density	**1050**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80 - 90**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Processing humidity	**≤0.07**	%	-
Melt temperature	**230 - 260**	°C	-
Mold temperature	**40 - 60**	°C	-
Zone 1	**180 - 210**	°C	-
Zone 2	**210 - 230**	°C	-
Zone 3	**230 - 240**	°C	-
Nozzle temperature	**230 - 240**	°C	-
Back pressure	**1 - 3**	MPa	-

Characteristics

Processing

Injection Molding

Applications

Automotive

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat

Regional Availability

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