

LUMIPLAS LD590T

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 Break	49	MPa	ASTM D 638
Elongation at Break	30	%	ASTM D 638
Flexural Modulus	2453	MPa	ASTM D 790
Flexural Strength	78.5	MPa	ASTM D 790
Rockwell Hardness	R 108	-	ASTM D 785
Izod Impact notched, 1/8 in	104	J/m	ASTM D 256
Izod Impact notched, 1/4 in	94.3	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
Coefficient of Thermal Expansion, MD	84	E-6/K	ASTM D 696
DTUL @ 264 psi	81	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1120	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	230 - 250	°C	-
Mold temperature	40 - 60	°C	-
Zone 1	190 - 210	°C	-
Zone 2	200 - 220	°C	-
Zone 3	220 - 250	°C	-
Nozzle temperature	230 - 250	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	1 - 4	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	230 - 250	°C	-
Zone 1	190 - 210	°C	-
Zone 2	200 - 230	°C	-
Zone 3	210 - 240	°C	-
Zone 4	220 - 250	°C	-
Nozzle temperature	220 - 250	°C	-

Characteristics**Processing**

Injection Molding, Other Extrusion

Special Characteristics

High impact or impact modified

Applications

Electrical and Electronical

Regional Availability

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

Features

Light Diffusing