

**LUMIPLAS LD7850**

ABS

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	11	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-
Mold Shrinkage, MD	0.0065	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength at Break	61.8	MPa	ASTM D 638
Elongation at Break	100	%	ASTM D 638
Flexural Modulus	2256	MPa	ASTM D 790
Flexural Strength	93.2	MPa	ASTM D 790
Rockwell Hardness	R 118	-	ASTM D 785
Izod Impact notched, 1/8 in	785	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	V-2	-	UL 94
Thickness tested	0.8	mm	-
Coefficient of Thermal Expansion, MD	68	E-6/K	ASTM D 696
DTUL @ 264 psi	130	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1200	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 120	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	300 - 320	°C	-
Mold temperature	80 - 120	°C	-
Zone 1	260 - 280	°C	-
Zone 2	280 - 300	°C	-
Zone 3	290 - 310	°C	-
Nozzle temperature	290 - 310	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	1 - 4	MPa	-

Processing Recommendation Extrusion	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 120	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	300 - 320	°C	-
Zone 1	260 - 280	°C	-
Zone 2	270 - 300	°C	-
Zone 3	270 - 300	°C	-
Zone 4	270 - 300	°C	-
Nozzle temperature	260 - 295	°C	-

**Characteristics****Processing**

Injection Molding, Other Extrusion

**Applications**

Electrical and Electronical

**Features**

Light Diffusing

**Regional Availability**

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