SolutionPartner

LG Chem

ABS HF380

Injection Molding

Description

High Flow

Application

Electric/electronic products, Miscellaneous Goods

구분	측정조건	규격	단위	수치
물리적 특성				
비중		ASTM D792	-	1.04~1.06
수축율, 3.2mm		ASTM D955	%	0.4~0.7
유동지수	220℃/10kg	ASTM D1238	g/10min	42
기계적 특성				
인장강도, 3.2mm		ASTM D638		
@ 항복점	50mm/min		kg/cm^2	450
인장신율, 3.2mm		ASTM D638		
@ 항복점	50mm/min		%	
@ 파단점	50mm/min		%	>10
굴곡강도, 3.2mm	15mm/min	ASTM D790	kg/cm^2	720
굴곡탄성율, 3.2mm	15mm/min	ASTM D790	kg/cm^2	24,000
아이조드 충격강도, 6.4mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	25
	-30℃		kg·cm/cm	12
아이조드 충격강도, 3.2mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	25
	-30℃		kg·cm/cm	12
Rockwell 경도	R-Scale	ASTM D785	-	106
열적 특성				
열변형온도, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	85
	4.6kg		℃	
Vicat 연화점		ASTM D1525		
	5kg, 50℃/h		℃	93
난연성		UL94		HB
Relative Temperature Index		UL 746B		
Electrical			℃	60
Mechanical with Impact			℃	60
Mechanical without Impact			℃	60

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.
Values given should not be interpreted as specification and not be used for part or tool design.
All properties, except melt flow rate are measured on injection molulded specimens and after 48 hours storage at 23℃, 50% relative humidty.

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사출성형 가이드

성형 조건		단위	Value
건조온도		℃	70~80
건조시간		hrs	2 ~ 4
최소 수분율		%	0.01
녹는점		℃	210 ~ 240
실린더 온도	Rear	℃	180 ~ 200
	Middle	℃	190 ~ 210
	Front	℃	200 ~ 220
노즐 온도		℃	200 ~ 230
금형온도		℃	40 ~ 70
배압		kg/cm^2	5 ~ 15
스크류 속도		%	30 ~ 60

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.
These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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