

ABS LG713

Extrusion Molding

Description

Low Gloss, Extrusion

Application

Automotive Interior Housing (Cover Etc)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.04
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.7
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	4
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	380
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	
@ Break	50mm/min		%	40
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm ²	620
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm ²	19,600
IZOD Impact Strength, 6.4mm (Notched)		ASTM D256		
	23℃		kg·cm/cm	23
	-30℃		kg·cm/cm	11
IZOD Impact Strength, 3.2mm (Notched)		ASTM D256		
	23℃		kg·cm/cm	26
	-30℃		kg·cm/cm	12
Rockwell Hardness	R-Scale	ASTM D785	-	96
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)		ASTM D648		
	18.6kg		℃	90
	4.6kg		℃	97
Vicat Softening Temperature		ASTM D1525		
	5kg, 50℃/h		℃	95
Flammability		UL94		
Relative Temperature Index		UL 746B		
Electrical			℃	
Mechanical with Impact			℃	
Mechanical without Impact			℃	
Optical				
Gloss	45°	ASTM D2457	-	30.0

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 moulded specimens and after 48 hours storage at 23℃, 50% relative humidity.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需更多物性资料请查阅 www.kedisujiao.com

备注：以上原料物性数据由厂家发布, 我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

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Processing Guide (Extrusion Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	70 ~ 80	
Drying Time	hrs	3 ~ 4	
Minimum Moisture Content	%	0.01	
Melt Temperature	°C	200 ~ 250	
Barrel Temperature	Zone 1	°C	180 ~ 210
	Zone 2	°C	190 ~ 230
	Zone 3	°C	200 ~ 250
	Zone 4	°C	200 ~ 250
Adapter Temperature	°C	200 ~ 250	
Die Temperature	°C	200 ~ 250	
Roll Stack Temperature	Top	°C	70 ~ 100
	Middle	°C	70 ~ 90
	Bottom	°C	60 ~ 90

Note) Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.

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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