

SolutionPartner


ABS LG749W

Injection Molding

Description

Low Gloss, Heat Resistance

Application

Automotive Interior Housing
(Glove Cover, Door S/W Housing 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	6
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	480
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	15
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm ²	750
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm ²	24,000
IZOD Impact Strength, 6.4mm (Notched)	23℃	ASTM D256	kg·cm/cm	24
	-30℃		kg·cm/cm	9
IZOD Impact Strength, 3.2mm (Notched)	23℃	ASTM D256	kg·cm/cm	27
	-30℃		kg·cm/cm	10
Rockwell Hardness	R-Scale	ASTM D785	-	106
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	℃	92
	4.6kg		℃	100
Vicat Softening Temperature	5kg, 50℃/h	ASTM D1525	℃	100
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 molded specimens and after 48 hours storage at 23℃, 50% relative humidity.

Updated : 27-Apr-17

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.

SolutionPartner


ABS LG749W

Injection Molding

Description

Low Gloss, Heat Resistance

Application

Automotive Interior Housing
(Glove Cover, Door S/W Housing Etc)

Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	80 ~ 90
Drying Time		hrs	3 ~ 4
Recommendable Moisture Content		%	0.05 below
Melt Temperature		°C	220 ~ 250
Cylinder Temperature	Rear	°C	180 ~ 200
	Middle	°C	200 ~ 220
	Front	°C	220 ~ 230
Nozzle Temperature		°C	220 ~ 230
Mold Temperature		°C	40~60
Back Pressure		kg/cm ²	10 ~ 30
Measuring Speed		rpm	Low speed

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.

Updated : 27-Apr-17

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.