LG-Yongxing

WeConnectScience

ABS HI-121H

Injection Molding Grade

Description

Well balanced mechanical properties

Application

Electric/electronic products, miscellaneous goods

Properties	Test Method	Test Condition	Unit	Typical Value
Physical	ASTM			
Melt Flow Rate	D1238	220℃/10kg	g/10min	21
Specific Gravity	D792	23℃		1.03
Molding Shrinkage	D955		%	0.4-0.7
Mechanical				
Tensile Strength 3.2mm	D638	50mm/min	kg/cm^2	500
Tensile Elongation 3.2mm	D638	50mm/min	%	25
Flexural Strength 6.4mm	D790	15mm/min	kg/cm^2	700
Flexural Modulus 6.4mm	D790	15mm/min	kg/cm^2	22000
IZOD Impact Strength 6.4mm	D256	23℃ -30℃	kg.cm/cm	23 -
Rockwell Hardness	D785	R-Scale		109
Thermal				
Heat Deflection Temperature, 6.4mm(Unannealed)	D648	18.6KG	℃	87
Vicat Softening Temperature	D1525	1kg	℃	95
Flammability	UL94	1.5mm	class	HB

Note:
The above values are only the representatives of the natural color specimen, not for guarantee.

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	75 ~ 85
Drying Time		hrs	2 ~ 4
Cylinder Temperature	Rear	℃	180 ~ 200
	Middle	℃	190 ~ 210
	Front	℃	200 ~ 220
Nozzle Temperature		℃	200 ~ 230
Melt Temperature		℃	210 ~ 240
Mold Temperature		℃	40 ~ 70
Injection pressure	injection pressure	MPa	60 ~ 100
	holding pressure	MPa	70 ~ 90
	Back pressure	MPa	0.5 ~ 1
Screw rotate speed		%	30 ~ 60

Note：These data only a general information to the best of our knowledge. It can not be guaranteed due to variance of materials, conditions and equipments.

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