

ABS AF345

Injection Molding

Description

Flame Retardant

Application

Electric/Electronic Applications(TV, Monitor Housing)
IT/OA device

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.19
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.7
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	37
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	430
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	5
@ Break	50mm/min		%	20
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	22,000
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm ²	700
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm ²	24,000
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23℃		kg-cm/cm	18
	-30℃		kg-cm/cm	6
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg-cm/cm	21
	-30℃		kg-cm/cm	6
Rockwell Hardness	R-Scale	ASTM D785	-	103
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	80
	4.6kg		℃	89
Vicat Softening Temperature		ASTM D1525		
	5kg, 50℃/h		℃	88
Flammability		UL94		
1.5mm			class	V-0
2.0mm			class	5VB
2.5mm			class	5VA
3.0mm			class	V-0
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 moulded specimens and after 48 hours storage at 23℃, 50% relative humidity.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要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！

ABS AF345

Injection Molding

Description

Flame Retardant

Application

Electric/Electronic Applications(TV, Monitor Housing)
IT/OA device

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.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要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！

ABS AF345

Injection Molding

Description

Flame Retardant

Application

Electric/Electronic Applications(TV, Monitor Housing)
IT/OA device

Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	℃	70 ~ 80	
Drying Time	hrs	2 ~ 4	
Minimum Moisture Content	%	0.01	
Melt Temperature	℃	200 ~ 230	
Cylinder Temperature	Rear	℃	170 ~ 190
	Middle	℃	180 ~ 200
	Front	℃	190 ~ 210
Nozzle Temperature	℃	200 ~ 230	
Mold Temperature	℃	40 ~ 60	
Back Pressure	kg/cm ²	5 ~ 10	
Screw Speed	rpm	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.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要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！