

MABS TR557

Injection Molding

Description

Transparency, High Impact

Application

Electric&Electronic Products

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.09
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	21
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	470
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	30
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm ²	700
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm ²	22,000
IZOD Impact Strength, 6.4mm (Notched)	23℃	ASTM D256	kg·cm/cm	17
IZOD Impact Strength, 3.2mm (Notched)	23℃	ASTM D256	kg·cm/cm	17
Rockwell Hardness	R-Scale	ASTM D785	-	107
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	℃	81
Optical				
Haze		ASTM D1003	%	2.0
Transparency		ASTM D1003	%	90

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 : 2-Mar-16

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.

MABS TR557

Injection Molding

Description

Transparency, High Impact

Application

Electric&Electronic Products

Processing Guide(Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	℃	80~90	
Drying Time	hrs	2 ~ 4	
Minimum Moisture Content	%	0.01	
Melt Temperature	℃	190 ~ 220	
Cylinder Temperature	Rear	℃	180 ~ 200
	Middle	℃	190 ~ 210
	Front	℃	200 ~ 220
Nozzle Temperature	℃	190 ~ 220	
Mold Temperature	℃	40 ~ 60	
Back Pressure	kg/cm ²	300 ~ 600	
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.

Updated : 2-Mar-16

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.