SolutionPartner

LG Chem

MABS XG569C

Injection Molding

Description

Anti-Scratch, High Gloss

Application

TV Front Cabinet, Bezel
Audio/Video Housing

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.1
Melt Flow Rate	220℃/10kg	ASTM D1238	g/10min	11
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm^2	600
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	30
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm^2	980
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm^2	29,000
IZOD Impact Strength, 6.4mm (Notched)	23℃	ASTM D256	kg·cm/cm	10
IZOD Impact Strength, 3.2mm (Notched)	23℃	ASTM D256	kg·cm/cm	10
Rockwell Hardness	R-Scale	ASTM D785	-	118
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	℃	84
Flammability		UL94		
1.6mm			class	HB
3.2mm			class	HB

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 molulded specimens and after 48 hours storage at 23℃, 50% relative humidty.

Updated : 2-Mar-16

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	80 ~ 90
Drying Time		hrs	3 ~ 4
Minimum Moisture Content		%	0.01
Melt Temperature		℃	200 ~ 230
Cylinder Temperature	Rear	℃	180 ~ 200
	Middle	℃	190 ~ 210
	Front	℃	200 ~ 220
Nozzle Temperature		℃	200 ~ 230
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.

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