



Solution*Partner*



ABS & ASA



 **LG Chem**

Grade Line-up

● General Purpose ABS

High Impact

- HI121H
- HI121
- HI100
- HI100H

High Gloss

- HG173
- SG175

High Flow

- HF380
- HF380G

Specialty

- High Stiffness**
 - HT700
- Anti-static**
 - AP163
- Paintability**
 - PT270
 - HF380I

● Extrusion ABS

General Extrusion

- General**
 - RS650
- High Impact**
 - SH610A

Refrigerator specialty

- Cyclo Pentane**
 - RS670
- HCFC**
 - LI965
- Solstice LBA**
 - LI963

● Flame Retardant ABS

Halogen

- 1.5mm V-0**
 - AF312A
 - AF312T
 - AF342
 - AF366(F)
 - AF364

- 2.0mm V-0**
 - AF312B
 - AF365
 - AF365F
 - AF365FM
 - AF365S

- 2.5mm V-0**
 - AF312C
 - AF332

Non-halogen

- V-2**
 - EF378L

● Anti-scratch ABS

High Gloss

- XG569C

High Impact & Flow

- XG570

High Flow & Metallic Feel

- XG571

● Transparent ABS

General Purpose

- TR558A
- TR557

Extrusion

- TR556

High Impact

- TR552

No Whitening

- TR552F

High Hardness

- TR551

● Metal Plating ABS

General Purpose

- MP211
- MP220

Medium Heat

- ER230
- XR231
- XR234

● Heat Resistance ABS

Medium Heat

- ER460
- ER461

Low Gloss & Low TVOC

- ER400
- ER400H
- XR410
- XR416
- XR440
- XR490

High Heat

- XR401
- XR401B
- XR404

Electrostatic Painting

- CX481

Extremely High Heat

- XR409H
- XR437
- XR439
- XR474

Blow Molding

- BM662B

● ASA (Construction)

General

- LI911F
- LI918
- LI921NS

Extrusion

- LI913
- LI923
- LI924
- LI925
- LI968W
- LI970
- LI980

Extrusion (Low Gloss)

- LI931C
- LI931T

● ASA (Automotive)

High Flow

- LI912
- LI928
- LI935

High Heat

- LI941
- LI945
- LI951

High Gloss

- LI938
- LI940

Low TVOC & Low Gloss ABS

ER400 / ER400H / XR410 / XR416 / XR440 / XR490

Properties	Test Method	Test Condition	Unit	Low TVOC & Low Gloss					
				ER400	ER400H	XR410	XR416	XR440	XR490
Physical Properties									
Density	ISO 1183		g/cm³	1.04	1.04	1.05	1.05	1.07	1.07
Melt Flow Rate	ISO 1133	220°C, 10kg	g/10min	8	5	7	6	5	3
Mold Shrinkage	ISO 294-4		%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Mechanical Properites									
Tensile Strength @Yield	ISO 527	50mm/min	MPa	52	40	50	37	50	50
Tensile Modulus	ISO 527	1mm/min	MPa	2,440	1,900	2,300	2,100	2,300	2,300
Flexural Strength	ISO 178	2mm/min	MPa	79	60	70	66	75	75
Flexural Modulus	ISO 178	2mm/min	MPa	2,400	2,000	2,350	2,100	2,400	2,400
Izod Impact Strength	ISO 180/1A	23°C	kJ/m²	21	36	16	22	11	13
(Notched)		-30°C	kJ/m²	8	10	8	10	6	6
Charpy Impact Strength	ISO 179/1eA	23°C	kJ/m²	21	36	13	22	11	13
(Notched)		-30°C	kJ/m²	9	10	8	10	6	6
Rockwell Hardness	ISO 2039		-	112	98	110	104	114	113
Thermal Properties									
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	95	92	97	97	104	107
(Annealed @80°C, 4 hrs)		0.45MPa	°C	98	95	100	100	108	110
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	85	82	86	86	93	97
(Unannealed)		0.45MPa	°C	92	89	94	94	100	104
Vicat Softening Temp.	ISO 306	50N, 50°C/hr	°C	101	98	107	107	112	115
Processing Guide									
Cylinder Temperature			°C	220~270	220~270	220~270	220~270	230~290	230~290
Mold Temperature			°C	40~80	40~80	40~80	40~80	40~80	40~80
Pre-drying		80~90°C	hrs	3~4	3~4	3~4	3~4	3~4	3~4

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High Heat Paintable ABS

ER460 / ER461 / XR401 / XR401B / CX481

Properties	Test Method	Test Condition	Unit	Medium Heat		High Heat		Electrostatic Painting
				ER460	ER461	XR401	XR401B	CX481
Physical Properties								
Density	ISO 1183		g/cm³	1.05	1.05	1.05	1.05	1.05
Melt Flow Rate	ISO 1133	220°C, 10kg	g/10min	23	14	9	11	7
Mold Shrinkage	ISO 294-4		%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Mechanical Properites								
Tensile Strength @Yield	ISO 527	50mm/min	MPa	45	49	49	50	42
Tensile Modulus	ISO 527	1mm/min	MPa	2,200	2,300	2,300	2,350	2,300
Flexural Strength	ISO 178	2mm/min	MPa	65	73	75	79	65
Flexural Modulus	ISO 178	2mm/min	MPa	2,300	2,350	2,350	2,450	2,200
Izod Impact Strength	ISO 180/1A	23°C	kJ/m²	22	23	23	15	6
(Notched)		-30°C	kJ/m²	8	8	8	7	3
Charpy Impact Strength	ISO 179/1eA	23°C	kJ/m²	22	25	23	14	6
(Notched)		-30°C	kJ/m²	8	9	9	7	3
Rockwell Hardness	ISO 2039		-	112	112	112	113	112
Thermal Properties								
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	90	93	94	101	93
(Annealed @80°C, 4 hrs)		0.45MPa	°C	95	102	105	105	103
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	82	85	88	90	85
(Unannealed)		0.45MPa	°C	90	97	100	97	95
Vicat Softening Temp.	ISO 306	50N, 50°C/hr	°C	100	101	106	107	105
Processing Guide								
Cylinder Temperature			°C	220~270	220~270	220~270	220~270	220~270
Mold Temperature			°C	40~80	40~80	40~80	40~80	40~80
Pre-drying		80~90°C	hrs	3~4	3~4	3~4	3~4	3~4

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Extremely High Heat ABS

XR437 / XR439 / XR409H / XR474 / BM662B

Properties	Test Method	Test Condition	Unit	Extremely High Heat				Blow Molding
				XR437	XR439	XR409H	XR474	BM662B
Physical Properties								
Density	ISO 1183		g/cm³	1.07	1.06	1.06	1.08	1.06
Melt Flow Rate	ISO 1133	220°C, 10kg	g/10min	7	6	3	3	2
Mold Shrinkage	ISO 294-4		%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Mechanical Properites								
Tensile Strength @Yield	ISO 527	50mm/min	MPa	45	43	49	46	45
Tensile Modulus	ISO 527	1mm/min	MPa	2,400	2,400	2,350	2,750	1,900
Flexural Strength	ISO 178	2mm/min	MPa	76	72	77	74	72
Flexural Modulus	ISO 178	2mm/min	MPa	2,600	2,400	2,400	2,750	1,950
Izod Impact Strength	ISO 180/1A	23°C	kJ/m²	14	10	16	12	16
(Notched)		-30°C	kJ/m²	7	4	8	6	7
Charpy Impact Strength	ISO 179/1eA	23°C	kJ/m²	13	11	15	12	15
(Notched)		-30°C	kJ/m²	7	4	8	6	7
Rockwell Hardness	ISO 2039		-	110	108	114	114	100
Thermal Properties								
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	102	106	108	110	101
(Annealed @80°C, 4 hrs)		0.45MPa	°C	108	111	111	113	105
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	95	98	99	102	93
(Unannealed)		0.45MPa	°C	102	106	106	109	100
Vicat Softening Temp.	ISO 306	50N, 50°C/hr	°C	116	118	117	122	110
Processing Guide								
Cylinder Temperature			°C	230~290	230~290	230~290	230~290	220~270
Mold Temperature			°C	40~80	40~80	40~80	40~80	40~80
Pre-drying		80~90°C	hrs	3~4	3~4	3~4	3~4	3~4

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Metal Plating ABS

MP220 / ER230 / XR231 / XR234

Properties	Test Method	Test Condition	Unit	Metal Plating			
				MP220	ER230	XR231	XR234
Physical Properties							
Density	ISO 1183		g/cm³	1.04	1.04	1.04	1.04
Melt Flow Rate	ISO 1133	220°C, 10kg	g/10min	20	23	17	11
Mold Shrinkage	ISO 294-4		%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Mechanical Properites							
Tensile Strength @Yield	ISO 527	50mm/min	MPa	44	43	42	41
Tensile Modulus	ISO 527	1mm/min	MPa	2,200	2,200	2,200	2,000
Flexural Strength	ISO 178	2mm/min	MPa	65	64	62	62
Flexural Modulus	ISO 178	2mm/min	MPa	2,300	2,300	2,400	2,250
Izod Impact Strength	ISO 180/1A	23°C	kJ/m²	25	26	23	16
(Notched)		-30°C	kJ/m²	14	14	13	7
Charpy Impact Strength	ISO 179/1eA	23°C	kJ/m²	26	26	24	18
(Notched)		-30°C	kJ/m²	14	14	14	8
Rockwell Hardness	ISO 2039		-	110	110	110	110
Thermal Properties							
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	93	95	98	101
(Annealed @80°C, 4 hrs)		0.45MPa	°C	103	105	102	112
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	83	84	87	92
(Unannealed)		0.45MPa	°C	94	96	93	103
Vicat Softening Temp.	ISO 306	50N, 50°C/hr	°C	100	102	105	111
Processing Guide							
Cylinder Temperature			°C	220~270	220~270	220~270	220~270
Mold Temperature			°C	40~80	40~80	40~80	40~80
Pre-drying		80~90°C	hrs	3~4	3~4	3~4	3~4

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ABS & ASA for Lighting

XR404 / LI935 / LI945

Properties	Test Method	Test Condition	Unit	High Heat ABS	High Heat ASA	
				XR404	LI935	LI945
Physical Properties						
Density	ISO 1183		g/cm³	1.05	1.08	1.09
Melt Flow Rate	ISO 1133	220°C, 10kg	g/10min	7	13	4
Mold Shrinkage	ISO 294-4		%	0.4~0.7	0.4~0.7	0.4~0.7
Mechanical Properites						
Tensile Strength @Yield	ISO 527	50mm/min	MPa	54	53	60
Tensile Modulus	ISO 527	1mm/min	MPa	2,450	2,100	2,750
Flexural Strength	ISO 178	2mm/min	MPa	82	76	95
Flexural Modulus	ISO 178	2mm/min	MPa	2,550	2,400	2,900
Izod Impact Strength	ISO 180/1A	23°C	kJ/m²	13	8	6
(Notched)		-30°C	kJ/m²	6	3	3
Charpy Impact Strength	ISO 179/1eA	23°C	kJ/m²	12	8	6
(Notched)		-30°C	kJ/m²	6	3	3
Rockwell Hardness	ISO 2039		-	114	112	115
Thermal Properties						
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	104	96	103
(Annealed @80°C, 4 hrs)		0.45MPa	°C	106	98	105
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	93	85	93
(Unannealed)		0.45MPa	°C	101	93	100
Vicat Softening Temp.	ISO 306	50N, 50°C/hr	°C	112	102	114
Processing Guide						
Cylinder Temperature			°C	230~290	220~270	220~270
Mold Temperature			°C	40~80	40~80	40~80
Pre-drying		80~90°C	hrs	3~4	3~4	3~4

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High Performance ASA

LI912 / LI928 / LI941 / LI951 / LI938 / LI940

Properties	Test Method	Test Condition	Unit	ASA				High Gloss	
				LI912	LI928	LI941	LI951	LI938	LI940
Physical Properties									
Density	ISO 1183		g/cm³	1.07	1.08	1.08	1.08	1.12	1.10
Melt Flow Rate	ISO 1133	220°C, 10kg	g/10min	12	26	6.5	7	9	8
Mold Shrinkage	ISO 294-4		%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Mechanical Properites									
Tensile Strength @Yield	ISO 527	50mm/min	MPa	45	47	48	50	45	45
Tensile Modulus	ISO 527	1mm/min	MPa	2,000	2,100	2,200	2,300	1,600	1,600
Flexural Strength	ISO 178	2mm/min	MPa	70	70	75	79	65	65
Flexural Modulus	ISO 178	2mm/min	MPa	2,100	2,200	2,400	2,500	1,800	2,000
Izod Impact Strength	ISO 180/1A	23°C	kJ/m²	13	11	12	11	10	10
(Notched)		-30°C	kJ/m²	2	2	2	4	2	2
Charpy Impact Strength	ISO 179/1eA	23°C	kJ/m²	13	11	11	11	10	10
(Notched)		-30°C	kJ/m²	2	2	2	4	2	2
Rockwell Hardness	ISO 2039		-	103	103	104	107	102	103
Thermal Properties									
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	89	92	98	107	81	90
(Annealed @80°C, 4 hrs)		0.45MPa	°C	96	101	106	104	92	101
Heat Deflection Temp.	ISO 75/Af	1.8MPa	°C	79	82	88	90	73	82
(Unannealed)		0.45MPa	°C	91	96	101	99	87	92
Vicat Softening Temp.	ISO 306	50N, 50°C/hr	°C	95	98	102	105	87	95
Processing Guide									
Cylinder Temperature			°C	220~270	220~270	220~270	220~270	220~270	220~270
Mold Temperature			°C	40~80	40~80	40~80	40~80	40~80	40~80
Pre-drying		80~90°C	hrs	3~4	3~4	3~4	3~4	3~4	3~4

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ABS

HI100 / HI100H / HI121 / HI121H

Properties		Test Condition	Test Method	Unit	High Imapct			
					HI100	HI100H	HI121	HI121H
Physical Properties								
Specific Gravity			ASTM D792	-	1.02	1.02	1.04	1.05
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	11	10	21	22
Mechanical Properites								
Tensile Strength		50mm/min	ASTM D638	kg/cm²	380	400	460	500
Tensile Elongation	@Yield	50mm/min	ASTM D638	%	>5			
	@Break			%	>10	>10	>10	>10
Tensile Modulus		1mm/min	ASTM D790	kg/cm²	16,400			
Flexural Strength		15mm/min	ASTM D790	kg/cm²	580	630	740	790
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	19,000	20,500	25,000	26,000
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	45	45	33	23
		-30°C		kg·cm/cm	25	25	15	
	3.2mm	23°C		kg·cm/cm	49	47	33	23
		-30°C		kg·cm/cm	25	25	13	
Rockwell Hardness		R-Scale	ASTM D785	-	92	94	108	110
Thermal Properties								
Heat Deflection Temp.	Unannealed	18.6kg		°C	84	84	85	85
		4.6kg		°C	94			
Vicat Softening Temp.	5kg/50	5kg/50		°C	90	92	93	92
	1kg/120	1kg/120		°C				
Flammability	UL94	1/8"		Class	HB (1.5mm) HB (1.5mm)			
		1/10"		Class				
		1/12"		Class				
		1/16"		Class	HB (3.0mm) HB (3.0mm)			
Optical Properties								
Haze	3mm	23°C/50% RH	ASTM D1003	%				
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%			
Gloss		45°C	ASTM D2457	-				

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ABS

HF380 / HF380G / HG173 / SG175G

Properties		Test Condition	Test Method	Unit	High Flow		High Gloss	
					HF380	HF380G	HG173	SG175G
Physical Properties								
Specific Gravity			ASTM D792	-	1.04	1.04	1.05	1.05
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	42	52	23	37
Mechanical Properites								
Tensile Strength		50mm/min	ASTM D638	kg/cm²	450	440	470	450
Tensile Elongation	@Yield	50mm/min	ASTM D638	%				
	@Break			%	>10	>10	>10	>10
Tensile Modulus		1mm/min	ASTM D790	kg/cm²				
Flexural Strength		15mm/min	ASTM D790	kg/cm²	720	710	740	720
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	24,000	24,500	25,500	25,500
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	25	25	24	
		-30°C		kg·cm/cm	12	12	10	
	3.2mm	23°C		kg·cm/cm	25	25	25	24
		-30°C		kg·cm/cm	12	12	10	
Rockwell Hardness		R-Scale	ASTM D785	-	106	106	109	110
Thermal Properties								
Heat Deflection Temp.	Unannealed	18.6kg		°C	85	85	85	85
		4.6kg		°C			89	
Vicat Softening Temp.	5kg/50	5kg/50		°C	93	93	93	92
	1kg/120	1kg/120		°C				
Flammability	UL94	1/8"		Class	HB	HB		HB
		1/10"		Class				
		1/12"		Class				
		1/16"		Class				
Optical Properties								
Haze	3mm	23°C/50% RH	ASTM D1003	%				
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%			
Gloss		45°C	ASTM D2457	-				

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PT270 / HF380I / HT700 / AP163

Properties		Test Condition	Test Method	Unit	Paintability		High Stiffness	Anti-static
					PT270	HF380I	HT700	AP163
Physical Properties								
Specific Gravity			ASTM D792	-	1.04	1.04	1.05	1.07
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	29	38	18	30
Mechanical Properites								
Tensile Strength		50mm/min	ASTM D638	kg/cm²	400	440	520	420
Tensile Elongation	@Yield	50mm/min	ASTM D638	%				
	@Break			%	>10	>10	>10	>10
Tensile Modulus		1mm/min	ASTM D790	kg/cm²	16,500		24,900	16,900
Flexural Strength		15mm/min	ASTM D790	kg/cm²	640	710	850	680
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	21,500	24,500	28,000	21,000
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	36	28	20	45
		-30°C		kg·cm/cm	20		7	
	3.2mm	23°C		kg·cm/cm	40	28	20	
		-30°C		kg·cm/cm	20		7	
Rockwell Hardness		R-Scale	ASTM D785	-	100	106	113	98
Thermal Properties								
Heat Deflection Temp.	Unannealed	18.6kg		°C	85	85	88	83
		4.6kg		°C	87		98	90
Vicat Softening Temp.	5kg/50	5kg/50		°C	92	93	95	93
	1kg/120	1kg/120		°C				
Flammability	UL94	1/8"		Class	HB (1.5mm)	HB (1.5mm)	HB	HB
		1/10"		Class				
		1/12"		Class				
		1/16"		Class	HB	HB (3.0mm)	HB	HB
Optical Properties								
Haze	3mm	23°C/50% RH	ASTM D1003	%				
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%			
Gloss		45°C	ASTM D2457	-				

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ABS

RS650 / RS657L / RS670 / SH610A

Properties		Test Condition	Test Method	Unit	Extrusion			
					RS650	RS657L	RS670	SH610A
Physical Properties								
Specific Gravity			ASTM D792	-	1.04	1.04	1.04	1.04
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	6	4.5	4.5	1
Mechanical Properites								
Tensile Strength		50mm/min	ASTM D638	kg/cm²	490	490	500	420
Tensile Elongation	@Yield	50mm/min	ASTM D638	%	>5	>5	>5	>5
	@Break			%	>15	>15	>15	>15
Tensile Modulus		1mm/min	ASTM D790	kg/cm²				
Flexural Strength		15mm/min	ASTM D790	kg/cm²	800	760	790	640
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	25,500	24,000	25,500	21,100
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	30	38	30	43
		-30°C		kg·cm/cm		16	11	
	3.2mm	23°C		kg·cm/cm	33	47	32	50
		-30°C		kg·cm/cm		17	12	
Rockwell Hardness		R-Scale	ASTM D785	-	107	105	106	97
Thermal Properties								
Heat Deflection Temp.	Unannealed	18.6kg		°C	87	89	89	87
		4.6kg		°C	95	94	94	92
Vicat Softening Temp.	5kg/50	5kg/50		°C	95	96	96	94
	1kg/120	1kg/120		°C				
Flammability	UL94	1/8"		Class	HB	HB	HB	HB
		1/10"		Class				
		1/12"		Class				
		1/16"		Class	HB	HB	HB	
Optical Properties								
Haze	3mm	23°C/50% RH	ASTM D1003	%				
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%			
Gloss		45°C	ASTM D2457	-				

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ABS

TR551 / TR552 / TR556 / TR557 / TR558A

Properties		Test Condition	Test Method	Unit	Transparent				
					TR551	TR552	TR556	TR557	TR558A
Physical Properties									
Specific Gravity			ASTM D792	-	1.12	1.06	1.09	1.09	1.1
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	8	11	5	21	25
Mechanical Properites									
Tensile Strength		50mm/min	ASTM D638	kg/cm²	580	400	480	470	510
Tensile Elongation	@Yield	50mm/min	ASTM D638	%	6	8	6	5	6
	@Break			%	>15	>15	>15	>15	>15
Tensile Modulus		1mm/min	ASTM D790	kg/cm²	27,000	17,000	21,500	21,000	24,000
Flexural Strength		15mm/min	ASTM D790	kg/cm²	970	640	800	720	800
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	29,000	19,000	23,500	23,000	26,000
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	12	22	20	17	12
		-30°C		kg·cm/cm	5	9	9	6	4
	3.2mm	23°C		kg·cm/cm	13	23	20	17	13
		-30°C		kg·cm/cm	5	9	9	6	4
Rockwell Hardness		R-Scale	ASTM D785	-	117	100	109	107	113
Thermal Properties									
Heat Deflection Temp.	Unannealed	18.6kg		°C	87	82	85	81	83
		4.6kg		°C	95	90	93	89	91
Vicat Softening Temp.	5kg/50	5kg/50		°C	95	90	93	89	91
	1kg/120	1kg/120		°C					
Flammability	UL94	1/8"		Class	HB	HB	HB	HB	HB
		1/10"		Class					
		1/12"		Class					
		1/16"		Class	HB	HB	HB	HB	HB
Optical Properties									
Haze	3mm	23°C/50% RH	ASTM D1003	%	1.9	2.2	2.3	2.0	1.8
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%	90	90	90	90
Gloss		45°C	ASTM D2457	-					

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ABS

MP211 / ER230 / XG569C / XG570

Properties		Test Condition	Test Method	Unit	Metal Plating		Anti-scratch	
					MP211	ER230	XG569C	XG570
Physical Properties								
Specific Gravity			ASTM D792	-	1.04	1.04	1.1	1.06
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	27	23	11	22
Mechanical Properites								
Tensile Strength		50mm/min	ASTM D638	kg/cm²	420	440	600	500
Tensile Elongation	@Yield	50mm/min	ASTM D638	%				
	@Break			%				
Tensile Modulus		1mm/min	ASTM D790	kg/cm²			27,000	27,000
Flexural Strength		15mm/min	ASTM D790	kg/cm²	720	650	970	840
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	25,500	23,000	29,000	29,000
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	23	24	10	17
		-30°C		kg·cm/cm			4	7
	3.2mm	23°C		kg·cm/cm	27	26	10	17
		-30°C		kg·cm/cm			4	7
Rockwell Hardness		R-Scale	ASTM D785	-	110	110	118	115
Thermal Properties								
Heat Deflection Temp.	Unannealed	18.6kg		°C	89	90	84	88
		4.6kg		°C			92	96
Vicat Softening Temp.	5kg/50	5kg/50		°C	99	102	92	96
	1kg/120	1kg/120		°C				
Flammability	UL94	1/8"		Class	HB	HB	HB	HB
		1/10"		Class				
		1/12"		Class				
		1/16"		Class	HB	HB		
Optical Properties								
Haze	3mm	23°C/50% RH	ASTM D1003	%				
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%			
Gloss		45°C	ASTM D2457	-				

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ABS

AF312A / AF312B / AF312C / AF364

Properties		Test Condition	Test Method	Unit	Flame Retardant			
					AF312A	AF312B	AF312C	AF364
Physical Properties								
Specific Gravity			ASTM D792	-	1.19	1.19	1.18	1.19
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	60	60	60	10
Mechanical Properites								
Tensile Strength		50mm/min	ASTM D638	kg/cm²	470	460	460	450
Tensile Elongation	@Yield	50mm/min	ASTM D638	%	5	5	5	5
	@Break			%	Min 20	Min 20	Min 20	Min 20
Tensile Modulus		1mm/min	ASTM D790	kg/cm²	24,000	23,000	23,000	23,000
Flexural Strength		15mm/min	ASTM D790	kg/cm²	720	750	720	750
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	27,000	28,000	27,000	25,000
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	21	22	23	16
		-30°C		kg·cm/cm	7	7	8	5
	3.2mm	23°C		kg·cm/cm	25	27	27	19
		-30°C		kg·cm/cm	7	8	8	7
Rockwell Hardness		R-Scale	ASTM D785	-	105	105	104	105
Thermal Properties								
Heat Deflection Temp.	Unannealed	18.6kg		°C	76	77	77	93
		4.6kg		°C	84	84	84	103
Vicat Softening Temp.	5kg/50	5kg/50		°C	83	84	84	100
	1kg/120	1kg/120		°C	-	-	-	-
Flammability	UL94	1/8"		Class	V-0	V-2 (1.0mm)	-	V-0
		1/10"		Class	V-0,5VB	V-0,5VB (2.1mm)	-	V-0,5VA
		1/12"		Class	V-0,5VA	V-0,5VA	V-0	-
		1/16"		Class	V-0,5VA	V-0,5VA	V-0	V-0,5VA
Optical Properties								
Haze	3mm	23°C/50% RH	ASTM D1003	%				
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%			
Gloss		45°C	ASTM D2457	-				

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ABS

AF365 / AF365F / AF366 / EF378L

Properties		Test Condition	Test Method	Unit	Flame Retardant			
					AF365	AF365F	AF366	EF378L
Physical Properties								
Specific Gravity			ASTM D792	-	1.19	1.18	1.19	1.06
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	30	75	25	58
Mechanical Properites								
Tensile Strength		50mm/min	ASTM D638	kg/cm²	470	420	420	450
Tensile Elongation	@Yield	50mm/min	ASTM D638	%	5	5	5	5
	@Break			%	Min 20	Min 20	Min 20	Min 20
Tensile Modulus		1mm/min	ASTM D790	kg/cm²	22,000	-	22,000	21,000
Flexural Strength		15mm/min	ASTM D790	kg/cm²	780	710	750	720
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	27,000	24,000	26,000	23,000
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	18	16	18	13
		-30°C		kg·cm/cm	6	5	6	
	3.2mm	23°C		kg·cm/cm	24	21	21	17
		-30°C		kg·cm/cm	8	6	7	
Rockwell Hardness		R-Scale	ASTM D785	-	108	105	108	105
Thermal Properties								
Heat Deflection Temp.	Unannealed	18.6kg		°C	86	84	84	78
		4.6kg		°C	92	91	90	85
Vicat Softening Temp.	5kg/50	5kg/50		°C	93	91	91	86
	1kg/120	1kg/120		°C				
Flammability	UL94	1/8"		Class	V-1 (1.7mm)	V-1 (1.7mm)	V-0	V-2
		1/10"		Class	V-0,5VB	V-0,5VB	V-0,5VB	
		1/12"		Class			V-0,5VA	
		1/16"		Class	V-0,5VA	V-0,5VA	V-0,5VA	V-2
Optical Properties								
Haze	3mm	23°C/50% RH	ASTM D1003	%				
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%			
Gloss		45°C	ASTM D2457	-				

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ABS

ER400 / XR410 / ER460 / ER461

Properties		Test Condition	Test Method	Unit	Heat Resistance			
					ER400	XR410	ER460	ER461
Physical Properties								
Specific Gravity			ASTM D792	-	1.04	1.05	1.04	1.05
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	7	7	22	14
Mechanical Properites								
Tensile Strength		50mm/min	ASTM D638	kg/cm²	540	490	460	500
Tensile Elongation	@Yield	50mm/min	ASTM D638	%	20	20	15	25
	@Break			%				
Tensile Modulus		1mm/min	ASTM D790	kg/cm²				
Flexural Strength		15mm/min	ASTM D790	kg/cm²	940	760	810	790
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	26,000	24,000	26,000	26,000
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	20	15	24	28
		-30°C		kg·cm/cm	9	8	10	10
	3.2mm	23°C		kg·cm/cm	29	16	24	30
		-30°C		kg·cm/cm	10	8	10	10
Rockwell Hardness		R-Scale	ASTM D785	-	110	107	110	110
Thermal Properties								
Heat Deflection Temp.	Unannealed	18.6kg		°C	92	97	92	93
		4.6kg		°C				100
Vicat Softening Temp.	5kg/50	5kg/50		°C	101	107	99	100
	1kg/120	1kg/120		°C				
Flammability	UL94	1/8"		Class	HB	HB	HB	HB
		1/10"		Class				
		1/12"		Class				
		1/16"		Class				
Optical Properties								
Haze	3mm	23°C/50% RH	ASTM D1003	%				
Total Light Transmission	3mm	23°C/50% RH	ASTM D1003	%				
Gloss		45°C	ASTM D2457	-				

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ABS

ER468 / XR401 / XR404 / XR409H / XR474

Properties		Test Condition	Test Method	Unit	Heat Resistance				
					ER468	XR401	XR404	XR409H	XR474
Physical Properties									
Specific Gravity			ASTM D792	-	1.04	1.05	1.05	1.06	1.07
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	35	9	7	3	3
Mechanical Properites									
Tensile Strength		50mm/min	ASTM D638	kg/cm²	460	500	500	500	480
Tensile Elongation	@Yield	50mm/min	ASTM D638	%	10	20	20	20	15
	@Break			%					
Tensile Modulus		1mm/min	ASTM D790	kg/cm²					
Flexural Strength		15mm/min	ASTM D790	kg/cm²	760	800	850	790	780
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	24,500	26,000	27,000	26,000	25,000
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	20	25	15	17	13
		-30°C		kg·cm/cm	-	8	6	6	5
	3.2mm	23°C		kg·cm/cm	30	27	17	18	14
		-30°C		kg·cm/cm	-	9	7	7	6
Rockwell Hardness		R-Scale	ASTM D785	-	109	110	112	111	113
Thermal Properties									
Heat Deflection Temp.	Unannealed	18.6kg		°C	92	97	100	106	112
		4.6kg		°C		106	108	115	120
Vicat Softening Temp.	5kg/50	5kg/50		°C	99	106	112	116	122
	1kg/120	1kg/120		°C					
Flammability	UL94	1/8"		Class	HB	HB	HB	HB	HB
		1/10"		Class					
		1/12"		Class					
		1/16"		Class					
Optical Properties									
Haze	3mm	23°C/50% RH	ASTM D1003	%					
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%				
Gloss		45°C	ASTM D2457	-					

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ASA

LI911 / LI918 / LI921NS

Properties		Test Condition	Test Method	Unit	General		
					LI911	LI918	LI921NS
Physical Properties							
Specific Gravity			ASTM D792	-	1.07	1.07	1.07
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	25	20	12
Mechanical Properites							
Tensile Strength		50mm/min	ASTM D638	kg/cm²	450	490	480
Tensile Elongation	@Yield	50mm/min	ASTM D638	%	>6	>6	>6
	@Break			%	40	25	25
Tensile Modulus		1mm/min	ASTM D790	kg/cm²	22,100		22,000
Flexural Strength		15mm/min	ASTM D790	kg/cm²	690	810	790
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	21,500	22,500	24,000
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	13	16	12
		-30°C		kg·cm/cm	4		3
	3.2mm	23°C		kg·cm/cm	20	17	14
		-30°C		kg·cm/cm	4		3
Rockwell Hardness		R-Scale	ASTM D785	-	97	104	103
Thermal Properties							
Heat Deflection Temp.	Unannealed	18.6kg		°C	86	86	86
		4.6kg		°C			96
Vicat Softening Temp.	5kg/50	5kg/50		°C	95	95	95
	1kg/120	1kg/120		°C			
Flammability	UL94	1/8"		Class		HB	
		1/10"		Class			
		1/12"		Class			
		1/16"		Class		HB	
Optical Properties							
Haze	3mm	23°C/50% RH	ASTM D1003	%			
Total Light Transmission	3mm	23°C/50% RH	ASTM D1003	%			
Gloss		45°C	ASTM D2457	-			

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ASA

LI913 / LI923 / LI924 / LI925

Properties		Test Condition	Test Method	Unit	Extrusion			
					LI913	LI923	LI924	LI925
Physical Properties								
Specific Gravity			ASTM D792	-	1.07	1.07	1.07	1.07
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	5	5	9	6
Mechanical Properites								
Tensile Strength		50mm/min	ASTM D638	kg/cm²	430	500	580	320
Tensile Elongation	@Yield	50mm/min	ASTM D638	%		>6	>6	
	@Break			%	35	25	20	100
Tensile Modulus		1mm/min	ASTM D790	kg/cm²				
Flexural Strength		15mm/min	ASTM D790	kg/cm²	650	790	880	460
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	19,500	24,000	28,000	13,500
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	34	18	7.5	34
		-30°C		kg·cm/cm	6	4		6
	3.2mm	23°C		kg·cm/cm	44	24	6	44
		-30°C		kg·cm/cm	6	4		6
Rockwell Hardness		R-Scale	ASTM D785	-	92	103	109	75
Thermal Properties								
Heat Deflection Temp.	Unannealed	18.6kg		°C	86	86	87	80
		4.6kg		°C				
Vicat Softening Temp.	5kg/50	5kg/50		°C	94	96	96	94
	1kg/120	1kg/120		°C				
Flammability	UL94	1/8”		Class	HB			HB
		1/10”		Class				
		1/12”		Class				
		1/16”		Class	HB			HB
Optical Properties								
Haze	3mm	23°C/50% RH	ASTM D1003	%				
Total Light Transmission	3mm	23°C/50% RH	ASTM D1003	%				
Gloss		45°C	ASTM D2457	-				

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ASA

LI965 / LI970 / LI980

Properties		Test Condition	Test Method	Unit	Extrusion		
					LI965	LI970	LI980
Physical Properties							
Specific Gravity			ASTM D792	-	1.07	1.12	1.09
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	4.5	12	17
Mechanical Properites							
Tensile Strength		50mm/min	ASTM D638	kg/cm²	450	470	370
Tensile Elongation	@Yield	50mm/min	ASTM D638	%		>6	>6
	@Break			%	10	25	85
Tensile Modulus		1mm/min	ASTM D790	kg/cm²	20,000		
Flexural Strength		15mm/min	ASTM D790	kg/cm²	700	730	570
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	21,500	21,000	16,000
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	26	13	9
		-30°C		kg·cm/cm	9	4	
	3.2mm	23°C		kg·cm/cm	28	18	
		-30°C		kg·cm/cm	9	4	
Rockwell Hardness		R-Scale	ASTM D785	-	101	103	86
Thermal Properties							
Heat Deflection Temp.	Unannealed	18.6kg		°C	88	82	80
		4.6kg		°C		91	
Vicat Softening Temp.	5kg/50	5kg/50		°C	95	90	
	1kg/120	1kg/120		°C			
Flammability	UL94	1/8”		Class			
		1/10”		Class			
		1/12”		Class			
		1/16”		Class			
Optical Properties							
Haze	3mm	23°C/50% RH	ASTM D1003	%			
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%		
Gloss		45°C	ASTM D2457	-			

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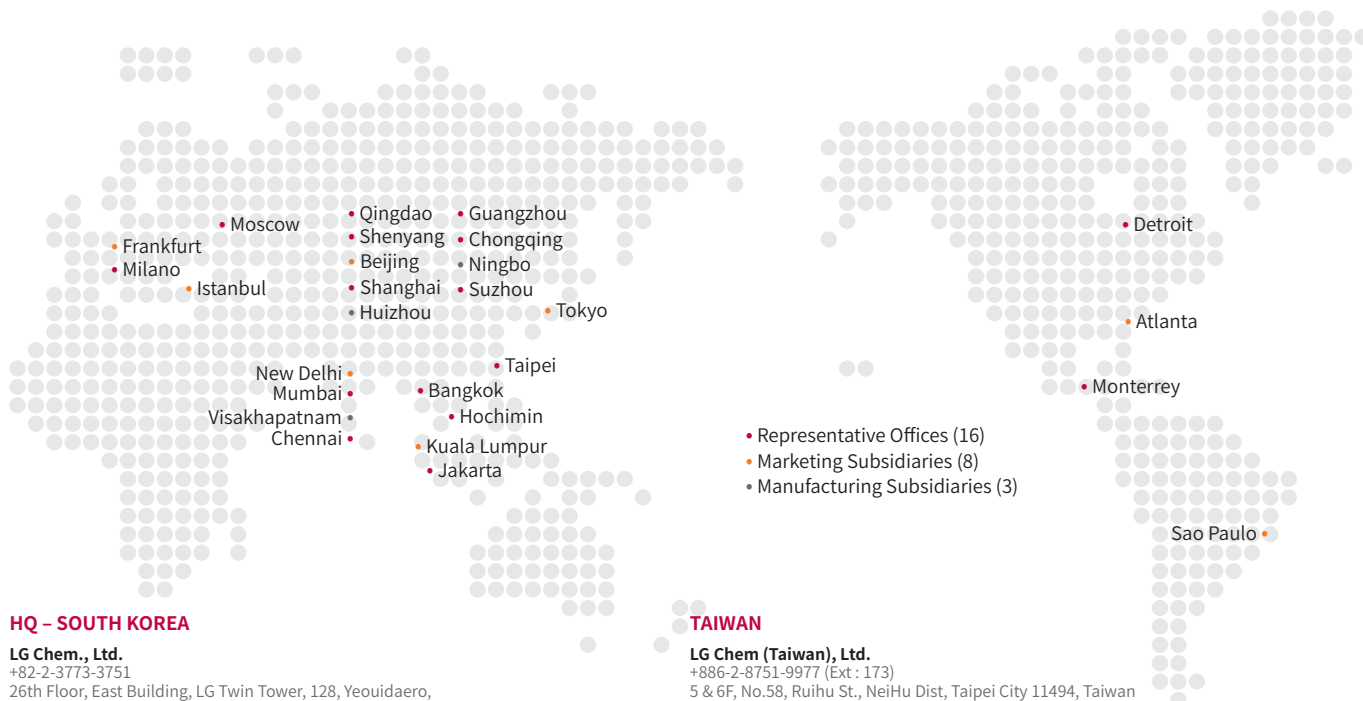
ASA

LI931C / LI931T / LI941

Properties		Test Condition	Test Method	Unit	Extrusion (Low Gloss)		Heat Resistance
					LI931C	LI931T	LI941
Physical Properties							
Specific Gravity			ASTM D792	-	1.09	1.07	1.08
Molding Shrinkage			ASTM D955	%	0.4~0.7	0.4~0.7	0.4~0.7
Melt Flow Rate		220°C, 10kg	ASTM D138	g/10min	6	7	6
Mechanical Properites							
Tensile Strength		50mm/min	ASTM D638	kg/cm²	300	330	480
Tensile Elongation	@Yield	50mm/min	ASTM D638	%	30	65	15
	@Break			%			
Tensile Modulus		1mm/min	ASTM D790	kg/cm²			
Flexural Strength		15mm/min	ASTM D790	kg/cm²	420	490	770
Flexural Modulus		15mm/min	ASTM D790	kg/cm²	13,500	15,000	23,500
Izod Impact Strength	6.4mm	23°C	ASTM D256	kg·cm/cm	7	8	14
		-30°C		kg·cm/cm		3	
	3.2mm	23°C		kg·cm/cm		9	
		-30°C		kg·cm/cm		4	
Rockwell Hardness		R-Scale	ASTM D785	-	80	81	104
Thermal Properties							
Heat Deflection Temp.	Unannealed	18.6kg		°C	78	79	94
		4.6kg		°C			
Vicat Softening Temp.	5kg/50	5kg/50		°C	87		102
	1kg/120	1kg/120		°C			
Flammability	UL94	1/8”		Class			HB
		1/10”		Class			
		1/12”		Class			
		1/16”		Class			HB
Optical Properties							
Haze	3mm	23°C/50% RH	ASTM D1003	%			
Total Light Transmission		3mm	23°C/50% RH	ASTM D1003	%		
Gloss		45°C	ASTM D2457	-	30	30	

Disclaimer 1) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

2) Values given in the table should not be interpreted as material specification and it can not be used for part or tool design.



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