

PRODUCT DATA SHEET

LEXALOY AB-120

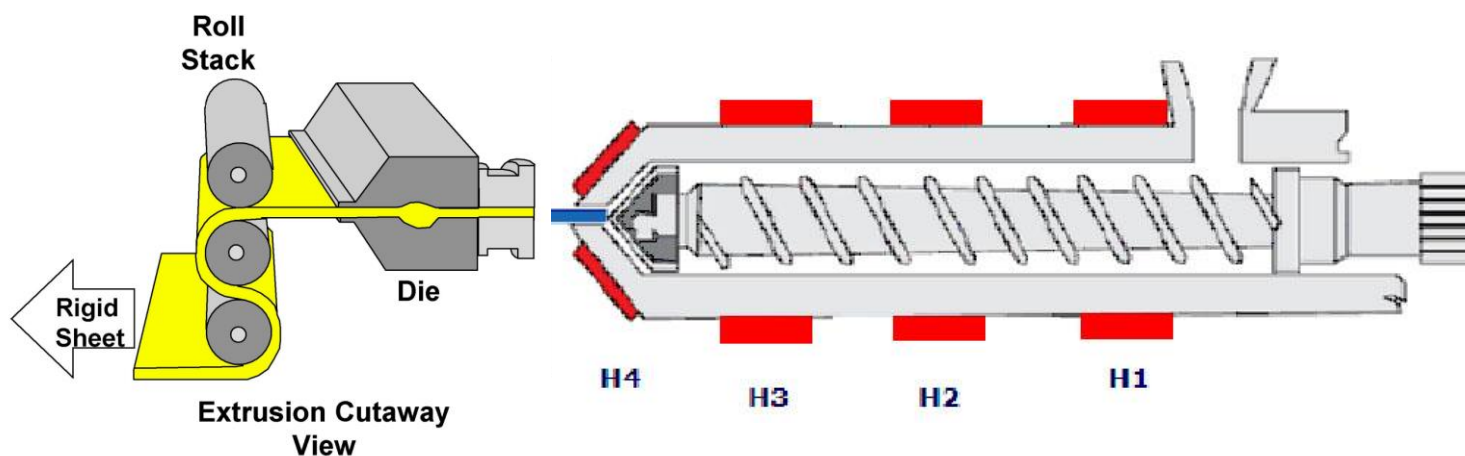
Description :

AB-120 is composed of Acrylonitrile Butadiene Styrene blend compound with specialized for sheet application. The product is available in black or color pellet form which have good processing window for sheet, specifically design to provide an excellent balance of stiffness and high impact, non chlorinated / brominated flame retardant grade that can be extruded. It has an MFR (220°C/10kg) of 20.

Application : Sheet extrusion

General properties	Value	Unit	Test method
Density	1.04	g/cm ³	ISO 1183
Melt flow rate ,@220°C, 10kgf	20	g/10min	ISO 1133
Melt flow rate ,@200°C, 5kgf	1.8	g/10min	ISO 1133
Shrink-rate	0.4 ~ 0.7	% (4~7/1,000)	ISO 294
Mechanical properties			
Izod impact strength, 4mm notched @+23°C	21	KJ / m ²	ISO 180
Tensile stress, @ yield, 50 mm/min	48	MPa	ISO 527-1.-2
Tensile strain, @ yield, 50 mm/min	21	%	ISO 527-1.-2
Flexural strength , 10 mm/min	75	MPa	ISO 178
Flexural modulus, 1% secant , 10 mm/min	2,330	MPa	ISO 178
Thermal properties			
Heat Deflection temperature @ 0.45 MPa, 4mm	92	°C	ISO 75-2
Flammability			
UL-94 method	-	1.5 mm	HB

PROCESSING GUIDE of AB-120



Parameter Injection Molding		Value	Unit
Drying Temperature		°C	75 ~ 85
Drying Time		Hr	2 ~ 3
Maximum moisture content		%	0.02
Melt Temperature		°C	210 ~ 220
Cylinder Temperature	H4	°C	210 ~ 220
	H3	°C	200~ 210
	H2	°C	190 ~ 200
	H1	°C	180 ~ 190
Die Temperature		°C	190 ~ 210
Roll Temperature		°C	80 ~ 110
Screw rotating speed		rpm	40 ~ 80