

# XR490

High Heat Resistance ABS, Automotive Interior Application, Low TVOC, Less Odor

## Description

- HKMC MS225-23 TB

## Applications

- Auto : Interior Part (Glove Box, Trunk Trim, Seat Belt Buckle, Console etc.)

| Properties                                        | Method      | Unit                   | XR490     |
|---------------------------------------------------|-------------|------------------------|-----------|
| <b>Physical</b>                                   |             |                        |           |
| Specific Gravity , 23°C                           | ISO 1183    |                        | 1.07      |
| Mold Shrinkage , 23°C, 3.2mm , 23°C               | ISO 294-4   | %                      | 0.4 ~ 0.7 |
| Melt Volume Rate , 220°C, 10kg                    | ISO 1133    | cm <sup>3</sup> /10min | 3         |
| <b>Mechanical</b>                                 |             |                        |           |
| Tensile Strength at Yield , 23°C, 50mm/min, 4mm   | ISO 527     | MPa                    | 50        |
| Tensile Elongation at Break , 23°C, 50mm/min, 4mm | ISO 527     | %, (Min)               | 15        |
| Tensile Modulus , 23°C, 1mm/min, 4mm              | ISO 527     | MPa                    | 2300      |
| Flexural Strength , 23°C, 2mm/min, 4mm            | ISO 178     | MPa                    | 75        |
| Flexural Modulus , 23°C, 2mm/min, 4mm             | ISO 178     | MPa                    | 2400      |
| Izod Impact Strength , Notched, 4mm, 23°C         | ISO 180/1A  | kJ/m <sup>2</sup>      | 13        |
| Izod Impact Strength , Notched, 4mm, -30°C        | ISO 180/1A  | kJ/m <sup>2</sup>      | 6         |
| Charpy Impact Strength , 4mm, 23°C                | ISO 179/1eA | kJ/m <sup>2</sup>      | 13        |
| Charpy Impact Strength , 4mm, -30°C               | ISO 179/1eA | kJ/m <sup>2</sup>      | 6         |
| Rockwell Hardness , R-Scale                       | ISO 2039    |                        | 113       |
| <b>Thermal</b>                                    |             |                        |           |
| HDT , Flatwise, 1.8MPa, 4mm, Unannealed           | ISO 75      | °C                     | 97        |
| VICAT , 50N, 50°C/h                               | ISO 306     | °C                     | 115       |

## Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors. Values given should not be interpreted as specification and not be used for designing part or tool. All properties, except melt flow rate are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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## Processing Guide (Injection Molding)

| Processing Parameters         | Unit               | Value     |
|-------------------------------|--------------------|-----------|
| Drying Temperature            | °C                 | 80 ~ 90   |
| Drying Time                   | hrs                | 3 ~ 4     |
| Moisture Content              | %                  | 0.05 ~    |
| Melt Temperature              | °C                 | 230 ~ 270 |
| Nozzle Temperature            | °C                 | 230 ~ 290 |
| Mold Temperature              | °C                 | 40 ~ 80   |
| Back Pressure, Hydraulic Type | kg/cm <sup>2</sup> | 10 ~ 30   |

## Note

Back Pressure & Measuring 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.