

ASTALOY™ PC/ABS MT7228HF

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS MT7228HF is a high melt flow, high heat resistance and high impact strength alloy of Polycarbonate & ABS which has been designed for injection moulding applications requiring a balance of exceptional impact toughness (especially at low temperatures), high product rigidity and a high heat resistance whilst maintaining easy processing and ease of decorative painting.
Note: The last letter U indicates additional UV stabilisation has been added [ie: ASTALOY™ PC/ABS MT7228HFU].

General Information			
Features	Good Processability		
	High Flow		
	High Heat Resistance		
	High Impact Resistance		
	High Rigidity		
	Low Temperature Impact Resistance		
	Paintable		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/3.8 kg	10	g/10 min	
260°C/5.0 kg	24	g/10 min	
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	56.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	150	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	92.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.50 mm)	680	J/m	ASTM D256
Gardner Impact (3.50 mm)	65.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	112	°C	
1.8 MPa, Unannealed, 6.40 mm	117	°C	
1.8 MPa, Unannealed, 12.7 mm	122	°C	

Vicat Softening Temperature	143	°C	ASTM D1525 ⁵
CLTE - Flow	7.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Flammability Index (1.60 mm)	650	°C	AS/NZS 60695.2.12
Injection	Nominal Value	Unit	
Drying Temperature	95.0 to 100	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	245 to 265	°C	
Middle Temperature	255 to 275	°C	
Front Temperature	265 to 285	°C	
Processing (Melt) Temp	260 to 290	°C	
Mold Temperature	50.0 to 90.0	°C	
Injection Pressure	60.0 to 140	MPa	
Injection Rate	Moderate		
Back Pressure	0.100 to 0.500	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	4.0 to 8.0	kN/cm ²	
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	Loading 1 (10 N)		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

