

ASTALAC™ ABS MDA80

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS MDA80 is a flame retardant, 7% fibre glass reinforced ABS injection moulding grade which meets the requirement of AS/NZS 60695.2.12 (IEC 60695-2-12) 960C glowwire flammability test. ASTALAC™ ABS MDA80 provides good balance of mouldability, superior flexural strength and rigidity and flame retardancy.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS MDA80UV].

General Information			
Filler / Reinforcement	Glass Fiber,7.0% Filler by Weight		
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Moldability		
	Good Strength		
	Medium Rigidity		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.40	%	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	45.0	MPa	ASTM D638
Flexural Modulus ² (3.20 mm)	4500	MPa	ASTM D790
Flexural Strength ³ (3.20 mm)	80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	85	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	100	°C	ASTM D648
Vicat Softening Temperature	115	°C	ASTM D1525 ⁴
Flammability	Nominal Value	Unit	Test Method
Glow Wire Ignition Temperature (1.60 mm)	960	°C	AS/NZS 60695.2.12
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 6.0	hr	
Rear Temperature	205 to 225	°C	

Middle Temperature	215 to 235	°C
Front Temperature	225 to 245	°C
Processing (Melt) Temp	230 to 240	°C
Mold Temperature	40.0 to 70.0	°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	3.0 to 6.0	kN/cm ²

NOTE

- | | |
|----|------------------|
| 1. | 5.0 mm/min |
| 2. | 1.3 mm/min |
| 3. | 1.3 mm/min |
| 4. | Loading 1 (10 N) |

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