

# ASTALOY™ PC/ABS MC300

Polycarbonate + ABS

Marplex Australia Pty. Ltd.

## Message:

ASTALOY™ PC/ABS MC300 is a general purpose alloy of ABS and Polycarbonate and is designed for injection moulding applications requiring a balance of high impact toughness, product rigidity, high heat resistance and mouldability. Typical applications in the automotive area include coloured interior doorhandles as well as instrument panel structural components and panels.

Note: The letters "U" or "W" indicate UV stabilisation has been added [ ie: ASTALOY™ PC/ABS MC300U ].

General Information			
Features	General Purpose Good Moldability High Heat Resistance High Impact Resistance Medium Rigidity		
Uses	Automotive Applications Automotive Instrument Panel General Purpose Handles		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/3.8 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.60	%	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 <sup>1</sup> (3.20 mm)	48.0	MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break, 3.20 mm)	50	%	ASTM D638
Flexural Modulus <sup>3</sup> (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength <sup>4</sup> (3.20 mm)	77.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	380	J/m	ASTM D256
Gardner Impact (3.20 mm)	35.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	90.0	°C	
1.8 MPa, Unannealed, 6.40 mm	95.0	°C	

1.8 MPa, Unannealed, 12.7 mm	102	°C	
Vicat Softening Temperature	122	°C	ASTM D1525 <sup>5</sup>
CLTE - Flow	7.6E-5	cm/cm/°C	ASTM D696
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Ignition Temperature (1.60 mm)	650	°C	AS/NZS 60695
<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>	
Drying Temperature	95.0 to 100	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	225 to 245	°C	
Middle Temperature	235 to 255	°C	
Front Temperature	245 to 265	°C	
Processing (Melt) Temp	240 to 270	°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 <sup>2</sup>	

#### 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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