

ASTALAC™ ABS 2041

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS 2041 is a general extrusion packaging grade developed for fast cycle thermoforming processing. It has an excellent balance of rigidity and impact strength and offers high stress crack resistance to a wide range of food stuffs. It is suitable for use in margarine tubs and lids. Underwriters Laboratory Reference E183535-B.

General Information	
Features	High ESCR (Stress Cracking Resistance)
	Impact resistance, good
	Fast molding cycle
	Medium hardness
Uses	Packaging
	Food packaging
UL File Number	E183535-B
Processing Method	Extrusion
	Thermoforming

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	1.0	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 ¹ (3.20 mm)	36.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	30	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2200	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	60.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	230	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	89.0	°C	ASTM D648
Vicat Softening Temperature	105	°C	ASTM D1525 ⁵
CLTE - Flow	8.8E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method

Flame Rating (1.60 mm)	HB	UL 94
Glow Wire Ignition Temperature (1.60 mm)	550	°C
		AS/NZS 60695.2.12
Injection	Nominal Value	Unit
Drying Temperature	85.0 - 90.0	°C
Drying Time	3.0 - 6.0	hr
Rear Temperature	190 - 220	°C
Middle Temperature	200 - 230	°C
Front Temperature	200 - 230	°C
Processing (Melt) Temp	200 - 240	°C
Extrusion	Nominal Value	Unit
Die Temperature	200 - 230	°C
Extrusion instructions		
Top Roll Temperature: 60 to 80°C Middle Roll Temperature: 70 to 90°C Bottom Roll Temperature: 60 to 80°C		
NOTE		
1.	5.0 mm/min	
2.	5.0 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	
5.	压力1 (10N)	

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