

ASTALAC™ ABS LGE

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS LGE is a high impact strength satin gloss grade of ABS and is designed for sheet extrusion applications requiring a satin gloss finish and superior toughness whilst maintaining a balance of easy formability and product rigidity.

General Information			
Features	Good Processability		
	High Impact Resistance		
	Medium Rigidity		
	Ultra High Toughness		
Uses	Sheet		
Processing Method	Sheet Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	10	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)	65		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	24.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	40	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	1400	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	40.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	400	J/m	ASTM D256
Gardner Impact (3.20 mm)	32.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	74.0	°C	
1.8 MPa, Unannealed, 12.7 mm	85.0	°C	
Vicat Softening Temperature	101	°C	ASTM D1525 ⁵
CLTE - Flow	9.0E-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 to 90.0	°C
Drying Time	3.0 to 6.0	hr
Processing (Melt) Temp	190 to 220	°C
Back Pressure	10.0 to 25.0	MPa
Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	170 to 190	°C
Cylinder Zone 2 Temp.	175 to 200	°C
Cylinder Zone 3 Temp.	180 to 205	°C
Cylinder Zone 4 Temp.	185 to 210	°C
Cylinder Zone 5 Temp.	190 to 220	°C
Die Temperature	180 to 220	°C
Take-Off Roll	75.0 to 105	°C

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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