ASTALOY™ PC/ABS TWG

Polycarbonate + ABS

Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS TWG is a high weldline impact strength alloy of ABS and Polycarbonate and is designed for injection moulding applications with multiple weldlines and requiring a balance of impact toughness, heat resistance, product rigidity, mouldability and easy painting. Typical applications in the automotive area are interior instrument panel fascia panels, console capping mouldings and glovebox assemblies, together with exterior painted components such as wheeltrims, front grilles, rear appliques and other trim panels.
Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALOY™ PC/ABS TWGU].

General Information			
Features	Good Moldability		
	High Heat Resistance		
	High Impact Resistance		
	Medium Rigidity		
	Paintable		
Uses	Automotive Applications		
	Automotive Exterior Parts		
	Automotive Interior Parts		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.12	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/3.8 kg	8.0	g/10 min	
260°C/5.0 kg	20	g/10 min	
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)	112		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (3.20 mm)	54.0	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	100	%	ASTM D638
Flexural Modulus [3] (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength [4] (3.20 mm)	86.0	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.20 mm)	600	J/m	ASTM D256
Gardner Impact (3.20 mm)	60.0	J	ASTM D3029
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648

1.8 MPa, Unannealed, 3.20 mm	102	°C	
1.8 MPa, Unannealed, 6.40 mm	107	°C	
1.8 MPa, Unannealed, 12.7 mm	112	°C	
Vicat Softening Temperature	135	°C	ASTM D1525 [5]
CLTE - Flow	7.2E-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
Injection	**Nominal Value**	**Unit**	
Drying Temperature	95.0 to 100	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	235 to 255	°C	
Middle Temperature	245 to 265	°C	
Front Temperature	255 to 275	°C	
Processing (Melt) Temp	250 to 280	°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)		

Recommended distributors for this material

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