

ASTALOY™ PC/ABS M150-28328

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS M150-28328 is highly pigmented, ultra high heat resistance and ultra high impact strength alloy of Polycarbonate/ABS and is designed for moulding applications requiring reduced light bleed and exceptional impact toughness, product rigidity, ultra high heat resistance whilst maintaining mouldability. Typical applications include light box display units
Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALOY™ PC/ABS M150U-28328].

General Information			
Features	Good Moldability		
	Good Stiffness		
	High Heat Resistance		
	Ultra High Impact Resistance		
Uses	Displays		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	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)	116		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)	130	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2750	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	90.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	550	J/m	ASTM D256
Gardner Impact (3.20 mm)	55.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	116	°C	
1.8 MPa, Unannealed, 6.40 mm	121	°C	
1.8 MPa, Unannealed, 12.7 mm	126	°C	
Vicat Softening Temperature	150	°C	ASTM D1525 ⁵
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Flammability Index (3.20 mm)	750	°C	AS/NZS 60695.2.12

Injection	Nominal Value	Unit
Drying Temperature	95.0 to 100	°C
Drying Time	3.0 to 5.0	hr
Rear Temperature	245 to 265	°C
Middle Temperature	255 to 275	°C
Front Temperature	265 to 285	°C
Processing (Melt) Temp	260 to 290	°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) |

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