

ASTALAC™ ABS AMG

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS AMG is a specialty automotive ABS injection moulding grade and is designed for use in the most difficult electroplating and painting applications. ASTALAC™ AMG offers an excellent balance of platability, paintability, impact toughness and mouldability. Typical automotive applications include painted rear appliques and grilles, electroplated lamp bezels and painted body-side strip mouldings.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS AMGUV].

General Information			
Features	Impact resistance, good		
	Electroplateable		
	Sprayable		
	Good formability		
Uses	Application in Automobile Field		
	Automotive exterior parts		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	45	g/10 min	ASTM D1238
230°C/3.8 kg	16	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)	107		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	42.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	35	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2250	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	70.0	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			ASTM D648
1.8 MPa, unannealed, 3.20mm	75.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	82.0	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	87.0	°C	ASTM D648
Vicat Softening Temperature	103	°C	ASTM D1525 ⁵

CLTE - Flow	6.5E-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	85.0 - 90.0	°C	
Drying Time	3.0 - 6.0	hr	
Rear Temperature	205 - 225	°C	
Middle Temperature	215 - 235	°C	
Front Temperature	225 - 245	°C	
Processing (Melt) Temp	220 - 250	°C	
Mold Temperature	40.0 - 70.0	°C	
Injection Rate	Slow		
Back Pressure	0.100 - 0.500	MPa	
Screw Speed	40 - 60	rpm	
Clamp Tonnage	3.0 - 6.0	kN/cm ²	
Injection instructions			
Injection Pressure: Minimum			
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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