

ASTABLEND™ MNM19

Acrylonitrile Butadiene Styrene + Nylon
Marplex Australia Pty. Ltd.

Message:

ASTABLEND™ MNM19 is an UV stabilized ABS/PA blend with very high impact strength. The grade features excellent melt flow properties resulting in outstanding processability and superb surface finish.

General Information				
Additive	UV Stabilizer			
Features	Good Flow			
	Good Processability			
	Outstanding Surface Finish			
	Ultra High Impact Resistance			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.07	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (240°C/10.0 kg)	30.0	--	cm ³ /10min	ISO 1133
Water Absorption (Equilibrium, 23°C, 50% RH)	1.3	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (4.00 mm)	2000	1600	MPa	ISO 527-2/50
Tensile Stress (4.00 mm)	43.0	34.0	MPa	ISO 527-2/50
Tensile Strain				ISO 527-2/50
Yield, 4.00 mm	3.0	--	%	
Break, 4.00 mm	28	--	%	
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	16	--	kJ/m ²	
23°C	71	--	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature ¹				
0.45 MPa, Unannealed	98.0	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	70.0	--	°C	ISO 75-2/A
Vicat Softening Temperature	180	106	°C	ISO 306/B50
Injection	Dry	Unit		
Drying Temperature	70.0 to 80.0		°C	
Drying Time	2.0		hr	
Rear Temperature	240 to 250		°C	

Middle Temperature	245 to 255	°C
Front Temperature	250 to 260	°C
Processing (Melt) Temp	245 to 265	°C
Mold Temperature	50.0 to 70.0	°C
Injection Pressure	60.0 to 120	MPa
Injection Rate	Moderate	
Back Pressure	0.100 to 0.500	MPa
Screw Speed	40 to 50	rpm
Clamp Tonnage	3.0 to 5.0	kN/cm ²
NOTE		

1. 10.0 x 4.0 mm

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