

ASTALAC™ ABS MGF10E

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS MGF10E is a 10% short fibre length glass filled ABS grade designed for extrusion or moulding into thick sections. This grade features improved rigidity & tensile strength compared to standard ABS extrusion grades, together with a reduced thermal expansion coefficient. These properties are preliminary only, pending full manufacturing runs.

Note: The letters "UV" indicate additional UV stabilisation has been added [ie: ASTALAC™ ABS MGF10EUV].

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Uses	Thick-walled Parts		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	104		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	61.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	5.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	3250	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	88.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	92.0	°C	
1.8 MPa, Unannealed, 6.40 mm	97.0	°C	
1.8 MPa, Unannealed, 12.7 mm	102	°C	
Vicat Softening Temperature	106	°C	ASTM D1525 ⁵
CLTE - Flow	5.5E-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
Extrusion	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 6.0	hr	

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
Melt Temperature	190 to 230	°C
Die Temperature	180 to 220	°C
Take-Off Roll	75.0 to 105	°C
Back Pressure	10.0 to 25.0	MPa

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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