

ASTALAC™ ABS M20

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS M20 is a medium/high heat resistance grade of ABS and is designed for injection moulding applications requiring a balance of heat resistance, impact toughness, product rigidity and mouldability. Typical automotive applications include steering column surrounds, glove-box lids and inner, rear tail light casings, door locking buttons and console lid substrate assemblies.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS M20UV].

General Information			
Features	Good Impact Resistance		
	Good Moldability		
	High Heat Resistance		
	Medium Rigidity		
Uses	Automotive Applications		
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	15	g/10 min	
230°C/3.8 kg	4.0	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)	104		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	43.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	40	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2300	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	72.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	220	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	82.0	°C	
1.8 MPa, Unannealed, 6.40 mm	88.0	°C	
1.8 MPa, Unannealed, 12.7 mm	93.0	°C	
Vicat Softening Temperature	108	°C	ASTM D1525 ⁵
CLTE - Flow	8.5E-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 to 90.0	°C
Drying Time	3.0 to 6.0	hr
Rear Temperature	205 to 225	°C
Middle Temperature	215 to 235	°C
Front Temperature	225 to 245	°C
Processing (Melt) Temp	220 to 250	°C
Mold Temperature	40.0 to 80.0	°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	3.0 to 6.0	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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