

ASTALAC™ ABS M200

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS M200 is a general purpose ABS injection moulding grade and offers an optimum balance of impact toughness, product rigidity, heat resistance and mouldability. Typical applications include vacuum cleaner casings, electronic consumer goods assemblies, whitegoods fascia panels and handles, coffin fittings and handles as well as telecommunications equipment.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS M200UV].

General Information			
Features	General Purpose		
Uses	General Purpose		
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	19	g/10 min	
230°C/3.8 kg	5.0	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)	102		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	41.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	55	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2250	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	71.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	280	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	77.0	°C	
1.8 MPa, Unannealed, 6.40 mm	83.0	°C	
1.8 MPa, Unannealed, 12.7 mm	88.0	°C	
Vicat Softening Temperature	102	°C	ASTM D1525 ⁵
CLTE - Flow	9.0E-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 60695.2.12
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 70.0	°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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