ASTALOY™ PC/ABS M130SHF

Polycarbonate + ABS

Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS M130SHF is a high melt flow alloy of ABS and Polycarbonate and is designed for long flow path injection moulding applications requiring a balance of impact toughness, product rigidity, heat resistance and mouldability. Typical automotive applications include painted exterior body panels, instrument panel substrates, remote locking keypads and tailgate upper air deflectors.
Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALOY™ PC/ABS M130SHFU].

General Information			
Features	Good Impact Resistance		
	Good Moldability		
	High Flow		
	Medium Heat Resistance		
	Medium Rigidity		
	Paintable		
Uses	Automotive Applications		
	Automotive Exterior Parts		
	Automotive Instrument Panel		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.11	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°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)	115		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (3.20 mm)	52.0	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	120	%	ASTM D638
Flexural Modulus [3] (3.20 mm)	2400	MPa	ASTM D790
Flexural Strength [4] (3.20 mm)	84.0	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.20 mm)	500	J/m	ASTM D256
Gardner Impact (3.20 mm)	55.0	J	ASTM D3029
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	96.0	°C	
1.8 MPa, Unannealed, 6.40 mm	99.0	°C	

1.8 MPa, Unannealed, 12.7 mm	105	°C	
Vicat Softening Temperature	128	°C	ASTM D1525 [5]
CLTE - Flow	7.2E-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	95.0 to 100	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	235 to 255	°C	
Middle Temperature	245 to 265	°C	
Front Temperature	255 to 275	°C	
Processing (Melt) Temp	250 to 280	°C	
Mold Temperature	50.0 to 90.0	°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	4.0 to 8.0	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)		

Recommended distributors for this material

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