ASTALAC™ ABS BSMG

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS BSMG is an ultra high melt flow ABS injection moulding grade which is designed for use in the most difficult flow path electroplating & painting applications. ASTALAC™ BSMG offers an optimum balance of mouldability, rigidity, heat resistance & impact toughness. Typical automotive applications include electroplated badges & painted exterior components.
Note: The letters "UV" or "W" indicate UV stabilisation [ie: ASTALAC™ ABS BSMGUV].

General Information			
Features	Good Impact Resistance		
	Good Moldability		
	High Flow		
	High Heat Resistance		
	Medium Rigidity		
	Paintable		
	Platable		
Uses	Automotive Applications		
	Automotive Exterior Parts		
Appearance	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.04	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	60	g/10 min	
230°C/3.8 kg	20	g/10 min	
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (3.20 mm)	44.0	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	30	%	ASTM D638
Flexural Modulus [3] (3.20 mm)	2350	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)	200	J/m	ASTM D256
Gardner Impact (3.20 mm)	18.0	J	ASTM D3029

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	78.0	°C	
1.8 MPa, Unannealed, 6.40 mm	83.0	°C	
1.8 MPa, Unannealed, 12.7 mm	87.0	°C	
Vicat Softening Temperature	103	°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	200 to 220	°C	
Middle Temperature	210 to 230	°C	
Front Temperature	220 to 240	°C	
Nozzle Temperature	225 to 245	°C	
Processing (Melt) Temp	225 to 245	°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)		

Recommended distributors for this material

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