

ASTAPET™ MDA282

Polybutylene Terephthalate + PET

Marplex Australia Pty. Ltd.

Message:

ASTAPET™ MDA282 is a 30% glass fibre filled grade of polybutylene terephthalate/recycled polyethylene terephthalate (PBT/PET) alloy. It is designed for applications where heat resistance and high rigidity are required and a good surface appearance is important. Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: Astaloy™ MDA282-U]. ASTAPET™ MDA282 is a development grade. The typical physical properties are based on limited experimental data and are subject to frequent review

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Rigidity, high		
	Heat resistance, high		
	Excellent appearance		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.55	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (285°C/2.16 kg)	60	g/10 min	ASTM D1238
Molding Shrinkage - Flow ¹ (3.00 mm)	0.20 - 0.60	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (3.20 mm)	110	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	2.0	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	6700	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	150	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	60	J/m	ASTM D256
Dart Drop Impact (3.20 mm)	5.00	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, unannealed, 3.20mm	180	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	180	°C	ASTM D648
Vicat Softening Temperature	200	°C	ASTM D1525 ⁶
CLTE - Flow	4.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method

Flame Rating (1.60 mm)	HB	UL 94
Additional Information		
CLTE, ASTM D696: 3e-5 to 5e-5 cm/cm/°CDTUL @ 264 psi, ASTM D648, 12.7 mm: >180°CDTUL @ 264 psi, ASTM D648, 3.2 mm: >180°CGlow Wire Temperature, AS 2420, 1.6 mm: 550°CVicat Softening Temperature, ASTM D1525, 1 kg: >200°C		
Injection	Nominal Value	Unit
Drying Temperature	140 - 150	°C
Drying Time	5.0 - 6.0	hr
Rear Temperature	250 - 260	°C
Middle Temperature	260 - 270	°C
Front Temperature	270 - 280	°C
Processing (Melt) Temp	270 - 290	°C
Mold Temperature	110 - 130	°C
Injection Pressure	60.0 - 140	MPa
Injection Rate	Slow-Moderate	
Back Pressure	0.300 - 1.00	MPa
Clamp Tonnage	3.0 - 6.0	kN/cm ²
Injection instructions		
Nozzle Temperature: Do not exceed stock temperatureScrew Speed: Minimum		
NOTE		
1.	D2 type	
2.	5.0 mm/min	
3.	5.0 mm/min	
4.	1.3 mm/min	
5.	1.3 mm/min	
6.	压力1 (10N)	

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