

Duroloy® AS-81

Polycarbonate + ABS

Unigel Plásticos

Message:

Medium flow rate and high impact grade.

For injection molding.

Main applications: automotive and electrical-electronic.

General Information			
Features	High Impact Resistance		
	Medium Flow		
Uses	Automotive Applications		
	Electrical/Electronic Applications		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	12	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow	0.55 to 0.75	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.20	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ASTM D638, ISO 527-2
Tensile Strength			ASTM D638, ISO 527-2
Yield	53.0	MPa	
Break	53.0	MPa	
Tensile Elongation			ASTM D638, ISO 527-2
Yield	5.0	%	
Break	130	%	
Flexural Modulus	2300	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	340	J/m	
23°C, 3.20 mm	600	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	127	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed, 3.20 mm	109	°C	ASTM D648
1.8 MPa, Unannealed	109	°C	ISO 75-2/A
Vicat Softening Temperature			

--	133	°C	ASTM D1525, ISO 306/B50 2 ¹
--	135	°C	ASTM D1525, ISO 306/B120 3 ²
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	4.0	hr	
Rear Temperature	250	°C	
Middle Temperature	260	°C	
Front Temperature	270	°C	
Nozzle Temperature	260	°C	
Processing (Melt) Temp	240 to 280	°C	
Mold Temperature	70.0 to 100	°C	
NOTE			
1.	Rate A (50°C/h), Loading 2 (50 N)		
2.	Rate B (120°C/h), Loading 2 (50 N)		

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