

ASTALOY™ PC/ASA KSV

Acrylonitrile Styrene Acrylate + PC
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ASA KSV is a non-halogenated, FR alloy of ASA and Polycarbonate which meets the stringent Underwriter's Laboratory UL94 V-0 test whilst offering a superior weathering performance to standard FR-ASA/PC alloys. ASTALOY™ PC/ASA KSV also features high heat resistance and exceptional impact toughness with typical applications including computer monitors and other electrical assemblies.
Note: The letters "U", "W" or "UV" indicate UV stabilisation has been added [ie: ASTALOY™ PC/ASA KSVU].

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
	Halogen Free		
	High Heat Resistance		
	High Impact Resistance		
Uses	Electrical/Electronic Applications		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/3.8 kg)	20	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)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	58.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 180	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2500	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	90.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	620	J/m	ASTM D256
Gardner Impact (3.20 mm)	60.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	98.0	°C	ASTM D648
Vicat Softening Temperature	112	°C	ASTM D1525 ⁵
CLTE - Flow	7.1E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		UL 94
Glow Wire Ignition Temperature (1.60 mm)	960	°C	AS/NZS 60695
Injection	Nominal Value	Unit	

Drying Temperature	95.0 to 100	°C
Drying Time	3.0 to 5.0	hr
Rear Temperature	235 to 270	°C
Middle Temperature	245 to 280	°C
Front Temperature	255 to 290	°C
Processing (Melt) Temp	245 to 290	°C
Mold Temperature	50.0 to 80.0	°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) |

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