

ASTALOY™ PC/ABS M150

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS M150 is an ultra high heat resistance and ultra high impact strength alloy of Polycarbonate/ABS and is designed for moulding applications requiring exceptional impact toughness, product rigidity, ultra high heat resistance whilst maintaining mouldability. Typical applications include automotive wheeltrims, grille components and domestic/industrial switchgear.
Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALOY™ PC/ABS M150U].

General Information			
Features	Good Moldability		
	High Heat Resistance		
	Medium Rigidity		
	Ultra High Impact Resistance		
Uses	Automotive Applications		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.16	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/3.8 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		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)	130	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2500	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	92.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	730	J/m	ASTM D256
Gardner Impact (3.20 mm)	80.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	112	°C	
1.8 MPa, Unannealed, 6.40 mm	118	°C	
1.8 MPa, Unannealed, 12.7 mm	125	°C	
Vicat Softening Temperature	143	°C	ASTM D1525 ⁵
CLTE - Flow	6.9E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Ignition Temperature (3.20 mm)	750	°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	245 to 265	°C
Middle Temperature	255 to 275	°C
Front Temperature	265 to 285	°C
Processing (Melt) Temp	260 to 290	°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) |

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