ASTALAC™ ABS EPF

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS EPF is an electroplatable ABS designed for maximum moulded component thermocycling performance to automotive requirements whilst offering a balance of easy platability, heat resistance, product toughness, rigidity and mouldability. Typical applications in the automotive area include electroplated grilles, rear decor panels, interior doorhandles and decorative exterior badges.
Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS EPFUV].

General Information	
Features	Electroplateable
	Good formability
	Heat resistance, medium
	Good toughness
	Medium hardness
Uses	Handle
	Application in Automobile Field
	Car interior parts
	Automotive exterior parts

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	19	g/10 min	ASTM D1238
230°C/3.8 kg	6.0	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)	106		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (3.20 mm)	40.0	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	35	%	ASTM D638
Flexural Modulus [3] (3.20 mm)	2300	MPa	ASTM D790
Flexural Strength [4] (3.20 mm)	70.0	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.20 mm)	250	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
1.8 MPa, unannealed, 3.20mm	83.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	88.0	°C	ASTM D648

1.8 MPa, unannealed, 12.7mm	94.0	°C	ASTM D648
Vicat Softening Temperature	111	°C	ASTM D1525 [5]
CLTE - Flow	6.5E-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 - 90.0	°C	
Drying Time	3.0 - 6.0	hr	
Rear Temperature	215 - 235	°C	
Middle Temperature	225 - 245	°C	
Front Temperature	235 - 255	°C	
Processing (Melt) Temp	230 - 260	°C	
Mold Temperature	50.0 - 80.0	°C	
Injection Rate	Slow		
Back Pressure	0.100 - 0.500	MPa	
Screw Speed	40 - 60	rpm	
Clamp Tonnage	3.0 - 6.0	kN/cm^2	
Injection instructions			
Injection Pressure: Minimum			
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	压 力1 (10N)		

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