

ASTALAC™ ABS X17

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS X17 is a high heat resistance grade of ABS and is designed for injection moulding applications requiring a balance of heat resistance, impact toughness, product rigidity and mouldability. Typical applications include automotive interior console assemblies, glove-box lids, door-liner armrest substrates, grilles and appliques.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS X17UV].

General Information			
Features	Impact resistance, good		
	Good formability		
	Heat resistance, high		
	Medium hardness		
Uses	Large household appliances and small household appliances		
	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	4.0	g/10 min	ASTM D1238
230°C/3.8 kg	1.5	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)	44.0	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)	73.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, unannealed, 3.20mm	85.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	92.0	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	100	°C	ASTM D648
Vicat Softening Temperature	115	°C	ASTM D1525 ⁵

CLTE - Flow	8.5E-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	90.0 - 95.0	°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	40.0 - 80.0	°C	
Injection Pressure	60.0 - 140	MPa	
Injection Rate	Moderate		
Back Pressure	0.100 - 0.500	MPa	
Screw Speed	40 - 60	rpm	
Clamp Tonnage	3.0 - 6.0	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.	压力1 (10N)		

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