

ASTALAC™ ABS M163

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS M163 is a medium flow, medium impact general purpose ABS injection moulding grade offering an excellent balance of impact toughness, product rigidity, heat resistance and easy mouldability.

General Information			
Features	General Purpose		
	Good Moldability		
	Medium Flow		
	Medium Heat Resistance		
	Medium Impact Resistance		
	Medium Rigidity		
Uses	General Purpose		
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	16	g/10 min	
230°C/3.8 kg	6.5	g/10 min	
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)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	50.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	35	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2500	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	80.0	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, 3.20 mm	82.0	°C	
1.8 MPa, Unannealed, 6.40 mm	88.0	°C	
1.8 MPa, Unannealed, 12.7 mm	92.0	°C	
Vicat Softening Temperature	105	°C	ASTM D1525 ⁵
CLTE - Flow	9.0E-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 60695.2.12
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 6.0	hr	
Rear Temperature	205 to 225	°C	
Middle Temperature	215 to 235	°C	
Front Temperature	225 to 245	°C	
Processing (Melt) Temp	220 to 250	°C	
Mold Temperature	40.0 to 70.0	°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	3.0 to 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.	Loading 1 (10 N)		

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

