

ASTALOY™ PC/ABS TWG-28328

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS TWG-28328 is a highly pigmented alloy of ABS and Polycarbonate and is designed for injection moulding applications requiring reduced light bleed and a balance of impact toughness, heat resistance, product rigidity, mouldability. Typical applications include light box display units. Note: The letters "U" as a suffix indicates UV stabilisation has been added [ie: ASTALOY™ PC/ABS TWGU-28328].

General Information			
Features	Good Impact Resistance		
	Good Moldability		
	Medium Heat Resistance		
	Medium Rigidity		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.29	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°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)	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)	100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2400	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)	450	J/m	ASTM D256
Gardner Impact (3.20 mm)	40.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	100	°C	
1.8 MPa, Unannealed, 6.40 mm	106	°C	
1.8 MPa, Unannealed, 12.7 mm	110	°C	
Vicat Softening Temperature	133	°C	ASTM D1525 ⁵
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	95.0 to 100	°C	

Drying Time	3.0 to 5.0	hr
Rear Temperature	235 to 255	°C
Middle Temperature	245 to 265	°C
Front Temperature	255 to 275	°C
Processing (Melt) Temp	250 to 280	°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) |

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



WECHAT