

ASTALAC™ ABS M140

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS M140 is a high heat profile extrusion grade of ABS and is designed for profile extrusion applications requiring a balance of high heat resistance, high toughness and abuse resistance, product rigidity and processability. Typical profile extrusion applications include electro deposition bath metal sheet racking supports and domestic/industrial window frame linings.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS M140UV].

General Information			
Features	Good Processability		
	High Heat Resistance		
	Medium Rigidity		
	Ultra High Toughness		
Uses	Profiles		
Processing Method	Profile Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	3.0	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)	102		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)	45	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2300	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	76.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	280	J/m	ASTM D256
Gardner Impact (3.20 mm)	20.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	89.0	°C	
1.8 MPa, Unannealed, 6.40 mm	95.0	°C	
1.8 MPa, Unannealed, 12.7 mm	102	°C	
Vicat Softening Temperature	116	°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 60695.2.12
Injection	Nominal Value	Unit
Drying Temperature	85.0 to 90.0	°C
Drying Time	3.0 to 6.0	hr
Processing (Melt) Temp	200 to 240	°C
Back Pressure	10.0 to 25.0	MPa
Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	180 to 200	°C
Cylinder Zone 2 Temp.	185 to 210	°C
Cylinder Zone 3 Temp.	190 to 215	°C
Cylinder Zone 4 Temp.	195 to 220	°C
Cylinder Zone 5 Temp.	200 to 230	°C
Die Temperature	200 to 230	°C
Take-Off Roll	75.0 to 105	°C
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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