

ASTALLOY™ PC/ABS EHA

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALLOY™ PC/ABS EHA is an electroplatable alloy of ABS and Polycarbonate and is designed for injection moulding applications requiring a balance of easy electroplatability, impact toughness, product rigidity, heat resistance and mouldability. Typical applications in the automotive field include electroplated grilles, garnishes and doorhandles.

Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALLOY™ PC/ABS EHAW].

General Information			
Features	Good Impact Resistance		
	Good Moldability		
	Medium Heat Resistance		
	Medium Rigidity		
	Platable		
Uses	Automotive Applications		
	Handles		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/3.8 kg	7.0	g/10 min	
260°C/5.0 kg	17	g/10 min	
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	113		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	51.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	88.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	500	J/m	ASTM D256
Gardner Impact (3.20 mm)	45.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	96.0	°C	
1.8 MPa, Unannealed, 6.40 mm	101	°C	

1.8 MPa, Unannealed, 12.7 mm	106	°C	
Vicat Softening Temperature	125	°C	ASTM D1525 ⁵
CLTE - Flow	7.0E-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	95.0 to 100	°C	
Drying Time	3.0 to 6.0	hr	
Rear Temperature	225 to 265	°C	
Middle Temperature	235 to 275	°C	
Front Temperature	245 to 285	°C	
Processing (Melt) Temp	240 to 290	°C	
Mold Temperature	60.0 to 100	°C	
Injection Rate	Slow		
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)		

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