

ASTALOY™ PC/ABS KMX

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS KMX is a flame retardant alloy of ABS and Polycarbonate and is designed to meet the stringent Underwriter's Laboratory UL94 V-0 test whilst offering an exceptional balance of impact toughness, product rigidity, heat resistance and mouldability. Typical applications include computer casing mouldings, electrical switchgear assemblies and whitegoods clothes dryer doors.
Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALOY™ PC/ABS KMXU].

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Impact Resistance		
	Good Moldability		
	Medium Heat Resistance		
	Medium Rigidity		
Uses	White Goods & Small Appliances		
UL File Number	E183535-C		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	2.5	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)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	53.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	60	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2400	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	86.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	400	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	98.0	°C	
1.8 MPa, Unannealed, 6.40 mm	105	°C	
1.8 MPa, Unannealed, 12.7 mm	111	°C	
Vicat Softening Temperature	134	°C	ASTM D1525 ⁵
CLTE - Flow	7.2E-5	cm/cm/°C	ASTM D696

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		UL 94
Glow Wire Flammability Index (1.60 mm)	960	°C	IEC 60695-2-12
Oxygen Index ⁶	31	%	ISO 4589-2
Injection	Nominal Value	Unit	
Drying Temperature	95.0 to 100	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	225 to 240	°C	
Middle Temperature	230 to 245	°C	
Front Temperature	235 to 250	°C	
Processing (Melt) Temp	235 to 245	°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)		
6.	Ambient Temperature		

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