

ASTAPET™ PC/PET MDA267

Polyethylene Terephthalate
Marplex Australia Pty. Ltd.

Message:

ASTAPET™ MDA267 is an alloy of Polycarbonate and 100% recycled polyethylene terephthalate (PET). Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: Astapet™ MDA267-U]. ASTAPET™ MDA267 is a development grade, the typical values detailed on this data sheet are based on limited data and are subject to frequent review

General Information			
Recycled Content	Yes, 100%		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (285°C/2.16 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow ¹ (3.00 mm)	0.40 - 0.80	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (3.20 mm)	50.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	200	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	2200	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	76.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	900	J/m	ASTM D256
Dart Drop Impact (3.20 mm)	70.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	116	°C	ASTM D648
0.45 MPa, unannealed, 12.7mm	138	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	77.0	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	83.0	°C	ASTM D648
Vicat Softening Temperature			
--	112	°C	ASTM D1525 ⁶
--	114	°C	ASTM D1525 ⁷
CLTE - Flow	6.5E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94

Additional Information

CLTE, ASTM D696: 6e-5 to 7e-5 cm/cm/°C
Elongation at Break, ASTM D638, 3.2 mm, 5.0 mm/min: >200%
Glow Wire Temperature, AS 2420, 1.6 mm: 550°C

Injection	Nominal Value	Unit
Drying Temperature	120 - 130	°C
Drying Time	4.0 - 6.0	hr
Rear Temperature	245 - 255	°C
Middle Temperature	250 - 260	°C
Front Temperature	255 - 265	°C
Processing (Melt) Temp	260 - 270	°C
Mold Temperature	20.0 - 60.0	°C
Injection Pressure	60.0 - 140	MPa
Injection Rate	Moderate	
Back Pressure	0.100 - 0.500	MPa
Screw Speed	40 - 60	rpm
Clamp Tonnage	3.0 - 6.0	kN/cm ²

Injection instructions

Nozzle Temperature: Do not exceed stock temperature

NOTE

- | | |
|----|------------|
| 1. | D2 type |
| 2. | 5.0 mm/min |
| 3. | 5.0 mm/min |
| 4. | 1.3 mm/min |
| 5. | 1.3 mm/min |
| 6. | 压力1 (10N) |
| 7. | 载荷2 (50N) |

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