

Sinkral® PD L 322

Acrylonitrile Butadiene Styrene

Versalis S.p.A.

Message:

Sinkral PD L 322 by continuous Mass, is a general purpose, high flow injection molding grade having good impact resistance coupled with an excellent gloss.

Designation: Thermoplastic ISO 2580-ABS 1, MG, 095-25-16-25

Widely used in the small and large household appliance sector, vacuum cleaners, toys, telephones and consumer electronics.

Grade available in natural color only.

The composition of this grade meets European Regulations for packaging in contact with foodstuffs.

General Information			
Features	Food Contact Acceptable		
	General Purpose		
	Good Impact Resistance		
	High Flow		
	High Gloss		
Uses	Appliances		
	Electrical/Electronic Applications		
	General Purpose		
	Toys		
Agency Ratings	EU Food Contact, Unspecified Rating		
Appearance	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	23	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.60	%	Internal Method
Water Absorption (23°C, 24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	109		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	45.0	MPa	ASTM D638
Tensile Elongation ² (Break)	20	%	ASTM D638
Flexural Modulus ³	2350	MPa	ASTM D790
Flexural Strength ⁴	69.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	kJ/m ²	DIN 53453

Charpy Unnotched Impact Strength			DIN 53453
-40°C	No Break		
23°C	No Break		
Notched Izod Impact			
-40°C, 3.20 mm	50	J/m	ISO 180/4A
-20°C, 3.20 mm	70	J/m	ISO 180/4A
0°C, 3.20 mm	100	J/m	ISO 180/4A
23°C, 3.20 mm	170	J/m	ISO 180/4A
-40°C ⁵	6.0	kJ/m²	ISO 180/1A
23°C ⁶	13	kJ/m²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Annealed)	96.0	°C	ASTM D648
Vicat Softening Temperature			
--	99.0	°C	ISO 306/A120
--	96.0	°C	ISO 306/B120
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Thermal Conductivity	0.17	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Electric Strength	30	kV/mm	IEC 60243-1
Dielectric Constant (1 kHz)	3.10		IEC 60250
Dissipation Factor (1 kHz)	0.015		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		Internal Method
Glow Wire Ignition Temperature (3.00 mm)	650	°C	IEC 60695-2-13
Additional Information	Nominal Value		
Designation	Thermoplastic ISO 2580-ABS 1,MG,095-25-16-25		
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 4.0	hr	
Processing (Melt) Temp	220 to 250	°C	
Mold Temperature	40.0 to 70.0	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		
5.	4 mm		
6.	4 mm		

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