

ASTALLOY™ PC/ABS M130

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALLOY™ PC/ABS M130 is a high weldline impact strength alloy of ABS and Polycarbonate and is designed for injection moulding applications with multiple cores and requiring a balance of impact toughness, heat resistance, product rigidity, mouldability and easy painting. Typical applications in the automotive area include wheeltrims, front grilles and other painted exterior trim panels.
Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALLOY™ PC/ABS M130U].

General Information			
Features	Good Impact Resistance		
	Good Moldability		
	Medium Heat Resistance		
	Medium Rigidity		
	Paintable		
Uses	Automotive Applications		
	Automotive Exterior Trim		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/3.8 kg)	6.5	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)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	52.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	83.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	630	J/m	ASTM D256
Gardner Impact (3.20 mm)	65.0	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	103	°C	
1.8 MPa, Unannealed, 12.7 mm	110	°C	
Vicat Softening Temperature	132	°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)	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 5.0	hr	
Rear Temperature	235 to 255	°C	
Middle Temperature	245 to 265	°C	
Front Temperature	255 to 275	°C	
Processing (Melt) Temp	250 to 280	°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)		

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