

ASTALOY™ PC/ABS A800LG

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS A800LG is a low gloss general purpose alloy of ABS and Polycarbonate and is designed for standard injection moulding applications requiring a low gloss finish, balance of high impact toughness, product rigidity, high heat resistance and mouldability. Typical applications include automotive interior components, seat belt surround, fascia panels and air vent mouldings.
Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALOY™ PC/ABS A800LGU].

General Information			
Features	General Purpose		
	Good Moldability		
	High Heat Resistance		
	High Impact Resistance		
	Low Gloss		
	Medium Rigidity		
Uses	Automotive Applications		
	Automotive Interior Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/3.8 kg	4.0	g/10 min	
260°C/5.0 kg	12	g/10 min	
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)	50.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2400	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	85.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	480	J/m	ASTM D256
Gardner Impact (3.20 mm)	60.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	100	°C	

1.8 MPa, Unannealed, 6.40 mm	105	°C	
1.8 MPa, Unannealed, 12.7 mm	112	°C	
Vicat Softening Temperature	135	°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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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