

ASTALAC™ ABS 2147

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS 2147 is an extrusion packaging grade developed for improved resistance to stress cracking and excellent tear resistance, particularly for thermoformed lids. It is designed for low temperature applications in contact with aggressive food stuffs. Underwriters Laboratory Reference E183535-B.

General Information	
Features	High ESCR (Stress Cracking Resistance)
	Good tear strength
	Compliance of Food Exposure
Uses	Packaging
	Cover
UL File Number	E183535-B
Processing Method	Extrusion
	Thermoforming

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	0.80	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)	106		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	32.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	35	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2000	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	56.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	250	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	87.0	°C	ASTM D648
Vicat Softening Temperature	103	°C	ASTM D1525 ⁵
CLTE - Flow	8.8E-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	85.0 - 90.0	°C
Drying Time	3.0 - 6.0	hr
Rear Temperature	190 - 220	°C
Middle Temperature	200 - 230	°C
Front Temperature	200 - 230	°C
Processing (Melt) Temp	200 - 240	°C

Extrusion	Nominal Value	Unit
Die Temperature	200 - 230	°C

Extrusion instructions

Top Roll Temperature: 60 to 80°C Middle Roll Temperature: 70 to 90°C Bottom Roll Temperature: 60 to 80°C

NOTE

- | | |
|----|------------|
| 1. | 5.0 mm/min |
| 2. | 5.0 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |
| 5. | 压力1 (10N) |

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