

ASTAPET™ PC/PET MDA288

Polyethylene Terephthalate

Marplex Australia Pty. Ltd.

Message:

ASTAPET™ MDA288 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™ MDA288 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
Molding Shrinkage - Flow ¹ (3.00 mm)	0.40 - 0.80	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
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)	2300	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	78.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Dart Drop Impact (3.20 mm)	40.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
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/°CElongation 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	

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