

ASTALAC™ ABS X15

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS X15 is a high heat resistance grade of ABS and is designed for injection moulding applications requiring a balance of heat resistance, impact toughness, product rigidity and mouldability. Typical automotive applications include interior console assemblies, glove-box lids, door-liner armrest substrate mouldings, wiper blade refill strips and whitegoods fascia panels.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS X15UV].

General Information			
Features	Good Impact Resistance		
	Good Moldability		
	High Heat Resistance		
	Medium Rigidity		
Uses	Automotive Applications		
	White Goods & Small Appliances		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	7.0	g/10 min	
230°C/3.8 kg	2.0	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)	106		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	44.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	35	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2400	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	72.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	85.0	°C	
1.8 MPa, Unannealed, 6.40 mm	93.0	°C	
1.8 MPa, Unannealed, 12.7 mm	100	°C	
Vicat Softening Temperature	115	°C	ASTM D1525 ⁵

CLTE - Flow	8.0E-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
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 95.0	°C	
Drying Time	3.0 to 6.0	hr	
Rear Temperature	215 to 235	°C	
Middle Temperature	225 to 245	°C	
Front Temperature	235 to 255	°C	
Processing (Melt) Temp	230 to 260	°C	
Mold Temperature	40.0 to 80.0	°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	3.0 to 6.0	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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