

ASTALAC™ ABS DMT

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS DMT is a high melt flow impact toughened ABS injection moulding grade designed for use in thin wall applications. ASTALAC™ DMT offers an optimum balance of impact toughness, rigidity, heat resistance and mouldability. Typical applications include telecommunications equipment such as telephones casings, telephone handsets as well as telephone cable clips and fittings.
Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ DMTUV].

General Information			
Additive	Impact Modifier		
Features	Good Impact Resistance		
	Good Moldability		
	High Flow		
	Impact Modified		
	Medium Heat Resistance		
	Medium Rigidity		
Uses	Telecommunications		
	Thin-walled Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	8.0	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)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	42.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	30	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	70.0	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			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	76.0	°C	
1.8 MPa, Unannealed, 12.7 mm	86.0	°C	
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
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 6.0	hr	
Rear Temperature	200 to 220	°C	
Middle Temperature	210 to 230	°C	
Front Temperature	220 to 240	°C	
Processing (Melt) Temp	215 to 245	°C	
Mold Temperature	40.0 to 70.0	°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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