

ASTALAC™ ABS M141

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS M141 is a high melt flow general purpose ABS injection moulding grade which combines easy flow with a balance of impact toughness, product rigidity and heat resistance. Typical applications include vacuum cleaner casings, electronic consumer goods, whitegoods fascia panels and handles as well as telecommunications equipment casings.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS M141UV].

| General Information | | | |
|--|------------------------------------|-------------------|-------------|
| Features | General Purpose | | |
| | Good Impact Resistance | | |
| | High Flow | | |
| | Medium Heat Resistance | | |
| | Medium Rigidity | | |
| Uses | Electrical/Electronic Applications | | |
| | General Purpose | | |
| | Handles | | |
| | Telecommunications | | |
| | 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) (230°C/3.8 kg) | 14 | 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) | 101 | | ASTM D785 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Strength ¹ (3.20 mm) | 46.0 | MPa | ASTM D638 |
| Tensile Elongation ² (Break, 3.20 mm) | 54 | % | ASTM D638 |
| Flexural Modulus ³ (3.20 mm) | 2300 | MPa | ASTM D790 |
| Flexural Strength ⁴ (3.20 mm) | 78.0 | MPa | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (3.20 mm) | 280 | J/m | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load | | | ASTM D648 |
| 1.8 MPa, Unannealed, 3.20 mm | 78.0 | °C | |
| 1.8 MPa, Unannealed, 12.7 mm | 88.0 | °C | |

| | | | |
|--|------------------|--------------------|-------------------------|
| Vicat Softening Temperature | 104 | °C | ASTM D1525 ⁵ |
| CLTE - Flow | 9.0E-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 60695.2.12 |
| Injection | Nominal Value | Unit | |
| Drying Temperature | 85.0 to 90.0 | °C | |
| Drying Time | 3.0 to 6.0 | hr | |
| Rear Temperature | 205 to 225 | °C | |
| Middle Temperature | 215 to 235 | °C | |
| Front Temperature | 225 to 245 | °C | |
| Processing (Melt) Temp | 220 to 250 | °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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