

ASTALOY™ ASA/PET MDA256

Acrylonitrile Styrene Acrylate + PET

Marplex Australia Pty. Ltd.

Message:

ASTALOY™ MDA256 is an alloy of ASA and 100% recycled polyethylene terephthalate (PET). Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALOY™ MDA256-U]. ASTALOY™ MDA256 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		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow ¹ (3.00 mm)	0.60 - 1.0	%	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	82		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (3.20 mm)	33.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	90	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	1500	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	50.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
3.20 mm	130	J/m	ASTM D256
-20°C, 3.20 mm	50	J/m	ASTM D256
Dart Drop Impact (3.20 mm)	30.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, unannealed, 3.20mm	66.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	75.0	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	83.0	°C	ASTM D648
Vicat Softening Temperature	112	°C	ASTM D1525 ⁶
CLTE - Flow	6.9E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Additional Information			

Glow Wire Temperature, AS 2420, 1.6 mm: 550°C

Injection	Nominal Value	Unit
Drying Temperature	100 - 120	°C
Drying Time	3.0 - 5.0	hr
Rear Temperature	215 - 235	°C
Middle Temperature	225 - 245	°C
Front Temperature	235 - 255	°C
Processing (Melt) Temp	240 - 260	°C
Mold Temperature	50.0 - 90.0	°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 |
| 6. | 压力1 (10N) |

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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