

# Terlux® 2802

Methyl Methacrylate / ABS  
INEOS Styrolution Group GmbH

## Message:

Terlux® 2802 is a standard injection molding grade based on a MABS polymer. Terlux® 2802 offers an unique combination of properties, such as a balanced stiffness/toughness ratio and the high transparency well known in SAN molding compositions.

| General Information                 |                                             |                        |             |
|-------------------------------------|---------------------------------------------|------------------------|-------------|
| Features                            | Balanced Stiffness/Toughness                |                        |             |
|                                     | Good Chemical Resistance                    |                        |             |
|                                     | Good Stiffness                              |                        |             |
|                                     | Good Surface Finish                         |                        |             |
|                                     | High Clarity                                |                        |             |
|                                     | High Impact Resistance                      |                        |             |
| Uses                                | Cosmetic Packaging                          |                        |             |
|                                     | Household Goods                             |                        |             |
|                                     | Housings                                    |                        |             |
|                                     | Sporting Goods                              |                        |             |
|                                     | Toys                                        |                        |             |
| Forms                               | Pellets                                     |                        |             |
| Processing Method                   | Injection Molding                           |                        |             |
| Multi-Point Data                    | Creep Modulus vs. Time (ISO 11403-1)        |                        |             |
|                                     | Isochronous Stress vs. Strain (ISO 11403-1) |                        |             |
|                                     | Isothermal Stress vs. Strain (ISO 11403-1)  |                        |             |
|                                     | Secant Modulus vs. Strain (ISO 11403-1)     |                        |             |
|                                     | Viscosity vs. Shear Rate (ISO 11403-2)      |                        |             |
| Physical                            | Nominal Value                               | Unit                   | Test Method |
| Density                             | 1.08                                        | g/cm <sup>3</sup>      | ISO 1183    |
| Apparent Density <sup>1</sup>       | 0.59                                        | g/cm <sup>3</sup>      |             |
| Melt Volume-Flow Rate (MVR)         |                                             |                        | ISO 1133    |
| 220°C/10.0 kg                       | 2.00                                        | cm <sup>3</sup> /10min |             |
| 220°C/21.6 kg                       | 17.0                                        | cm <sup>3</sup> /10min |             |
| Molding Shrinkage                   | 0.40 to 0.70                                | %                      | ISO 294-4   |
| Water Absorption (Saturation, 23°C) | 0.70                                        | %                      | ISO 62      |
| Hardness                            | Nominal Value                               | Unit                   | Test Method |
| Ball Indentation Hardness           | 70.0                                        | MPa                    | ISO 2039-1  |
| Mechanical                          | Nominal Value                               | Unit                   | Test Method |

|                                        |                         |                   |             |
|----------------------------------------|-------------------------|-------------------|-------------|
| Tensile Modulus                        | 2000                    | MPa               | ISO 527-2   |
| Tensile Stress (Yield, 23°C)           | 48.0                    | MPa               | ISO 527-2   |
| Tensile Strain (Yield, 23°C)           | 4.0                     | %                 | ISO 527-2   |
| Nominal Tensile Strain at Break (23°C) | 12                      | %                 | ISO 527-2   |
| Tensile Creep Modulus (1000 hr)        | 1250                    | MPa               | ISO 899-1   |
| Flexural Stress                        | 70.0                    | MPa               | ISO 178     |
| Impact                                 | Nominal Value           | Unit              | Test Method |
| Charpy Notched Impact Strength         |                         |                   | ISO 179     |
| -30°C                                  | 2.0                     | kJ/m <sup>2</sup> |             |
| 23°C                                   | 5.0                     | kJ/m <sup>2</sup> |             |
| Charpy Unnotched Impact Strength       |                         |                   | ISO 179     |
| -30°C                                  | 80                      | kJ/m <sup>2</sup> |             |
| 23°C                                   | 120                     | kJ/m <sup>2</sup> |             |
| Thermal                                | Nominal Value           | Unit              | Test Method |
| Heat Deflection Temperature            |                         |                   |             |
| 0.45 MPa, Annealed                     | 94.0                    | °C                | ISO 75-2/B  |
| 1.8 MPa, Annealed                      | 90.0                    | °C                | ISO 75-2/A  |
| Vicat Softening Temperature            |                         |                   |             |
| --                                     | 105                     | °C                | ISO 306/A50 |
| --                                     | 93.0                    | °C                | ISO 306/B50 |
| CLTE - Flow                            | 8.0E-5 to 1.1E-4        | cm/cm/°C          | ISO 11359-2 |
| Thermal Conductivity                   | 0.17                    | W/m/K             | DIN 52612   |
| Electrical                             | Nominal Value           | Unit              | Test Method |
| Surface Resistivity                    | 1.0E+15                 | ohms              | IEC 60093   |
| Volume Resistivity                     | 1.0E+15                 | ohms · cm         | IEC 60093   |
| Dielectric Constant (100 Hz)           | 2.90                    |                   | IEC 60250   |
| Dissipation Factor                     |                         |                   | IEC 60250   |
| 100 Hz                                 | 0.016                   |                   |             |
| 1 MHz                                  | 0.014                   |                   |             |
| Optical                                | Nominal Value           |                   | Test Method |
| Refractive Index                       | 1.540                   |                   | ISO 489     |
| Injection                              | Nominal Value           | Unit              |             |
| Drying Temperature                     | 70.0                    | °C                |             |
| Drying Time                            | 2.0                     | hr                |             |
| Processing (Melt) Temp                 | 230 to 260              | °C                |             |
| Mold Temperature                       | 60.0                    | °C                |             |
| Injection Velocity                     | 200                     | mm/sec            |             |
| NOTE                                   |                         |                   |             |
| 1.                                     | With external lubricant |                   |             |

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