

ASTALOY™ PC/ASA 407

Acrylonitrile Styrene Acrylate + PC

Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ASA 407 is a specialty modified alloy of ASA and Polycarbonate which is designed for automotive injection moulding applications requiring a exceptional depth of dark colours as well as balance of UV stability, impact toughness, product rigidity, heat resistance and mouldability. Typical applications include exterior automotive coloured grilles, station wagon roof rails and B-pillars.

Note: The letters "U" or "W" indicate additional UV stabilisation has been incorporated [ie: ASTALOY™ PC/ASA 407U].

UV stabilized version meets: GM, GMW15583P-ASA+PC-T4

General Information			
Features	Good Impact Resistance		
	Good Moldability		
	Good UV Resistance		
	Medium Heat Resistance		
	Medium Rigidity		
Uses	Automotive Applications		
	Automotive Exterior Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/3.8 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	58.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	400	J/m	ASTM D256
Gardner 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, 3.20 mm	91.0	°C	
1.8 MPa, Unannealed, 6.40 mm	97.0	°C	
1.8 MPa, Unannealed, 12.7 mm	104	°C	

Vicat Softening Temperature	125	°C	ASTM D1525 ⁵
CLTE - Flow	7.4E-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	95.0 to 100	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	225 to 245	°C	
Middle Temperature	235 to 255	°C	
Front Temperature	245 to 265	°C	
Processing (Melt) Temp	240 to 280	°C	
Mold Temperature	50.0 to 90.0	°C	
Injection Pressure	60.0 to 140	MPa	
Injection Rate	Slow-Moderate		
Back Pressure	0.100 to 0.500	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	4.0 to 8.0	kN/cm ²	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	Loading 1 (10 N)		

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