

ASTALAC™ ABS GF20

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS GF20 is a 20% glass filled general purpose ABS and is designed for injection moulding applications requiring a high product rigidity, high heat resistance and high creep resistance. Typical applications include industrial electrical switches and controllers, furniture mounting brackets, electrical pump casings and automotive heater air directional control valves.

Note: The letters "UV" or "W" indicate UV stabilisation [ie: ASTALAC™ ABSGF20-UV].

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	General Purpose		
	Good Creep Resistance		
	High Heat Resistance		
	High Rigidity		
Uses	Automotive Applications		
	Electrical/Electronic Applications		
	General Purpose		
	Industrial Applications		
	Pump Parts		
	Switches		
	Valves/Valve Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	85.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	5.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	5500	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	115	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	65	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed, 12.7 mm)	102	°C	ASTM D648
Vicat Softening Temperature	114	°C	ASTM D1525 ⁵
CLTE - Flow	5.0E-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
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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