Duroloy® AS-61

Polycarbonate + ABS

Unigel Plásticos

Message:

Medium flow rate and good impact resistance at low temperatures.
For injection molding.
Main applications: automotive and electrical-electronic.

General Information			
Features	Low Temperature Impact Resistance Medium Flow		
Uses	Automotive Applications Electrical/Electronic Applications		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.13	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	12	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow	0.55 to 0.75	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.20	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2200	MPa	ASTM D638, ISO 527-2
Tensile Strength			ASTM D638, ISO 527-2
Yield	47.0	MPa	
Break	47.0	MPa	
Tensile Elongation			ASTM D638, ISO 527-2
Yield	5.0	%	
Break	110	%	
Flexural Modulus	2300	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	380	J/m	
23°C, 3.20 mm	470	J/m	
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, Unannealed	122	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed, 3.20 mm	100	°C	ASTM D648
1.8 MPa, Unannealed	100	°C	ISO 75-2/A
Vicat Softening Temperature			

--	118	°C	ASTM D1525, ISO 306/B50 2 [1]
--	120	°C	ASTM D1525, ISO 306/B120 3 [2]

Flammability	Nominal Value	Test Method
Flame Rating (1.50 mm)	HB	UL 94

Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	4.0	hr
Rear Temperature	250	°C
Middle Temperature	260	°C
Front Temperature	270	°C
Nozzle Temperature	260	°C
Processing (Melt) Temp	240 to 280	°C
Mold Temperature	70.0 to 100	°C

NOTE	
1.	Rate A (50°C/h), Loading 2 (50 N)
2.	Rate B (120°C/h), Loading 2 (50 N)

Recommended distributors for this material

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