

ASTALAC™ ABS KMD

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS KMD was upgraded in November 2007 to comply with RoHS and is a general purpose flame retardant ABS which meets the stringent AS/NZS 60695.2.12 (IEC 60695-2-12) 960 deg C Glow Wire flammability test offering an optimum balance of flame retardency, impact toughness, indoor colour stability, heat resistance, product rigidity and mouldability. Typical applications include dishwasher fascia panels, household heater casings and whitegood control panel assemblies.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS KMDUV].

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
	General Purpose		
	Good Color Stability		
	Good Impact Resistance		
	Good Moldability		
	Medium Heat Resistance		
Uses	Medium Rigidity		
	General Purpose		
		White Goods & Small Appliances	
RoHS Compliance		RoHS Compliant	
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	98		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	39.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	40	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2250	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	68.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	260	J/m	ASTM D256
Gardner Impact (3.20 mm)	25.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

1.8 MPa, Unannealed, 3.20 mm	73.0	°C	
1.8 MPa, Unannealed, 12.7 mm	85.0	°C	
Vicat Softening Temperature	100	°C	ASTM D1525 ⁵
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Glow Wire Ignition Temperature (1.60 mm)	960	°C	AS/NZS 60695.2.12
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	195 to 215	°C	
Middle Temperature	205 to 225	°C	
Front Temperature	215 to 235	°C	
Processing (Melt) Temp	210 to 240	°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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