

Sinkral® PD D 232/M4

Acrylonitrile Butadiene Styrene

Versalis S.p.A.

Message:

Special very low gloss extrusion / co-extrusion grade, with good flow.

Designation: Thermoplastic ISO 2580-ABS 1,EGN,105-08-09-15

Sinkral PD D 232/M4 is widely used in the extrusion / co-extrusion of foils, when a very high matt appearance is required, as well as in the extrusion of profiles.

This grade is available in natural color only

General Information			
Features	Good Flow		
	Low Gloss		
Uses	Profiles		
Appearance	Matte Finish		
	Natural Color		
Forms	Pellets		
Processing Method	Coextrusion		
	Extrusion		
	Profile Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	8.0	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.60	%	Internal Method
Water Absorption (23°C, 24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	97		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	27.0	MPa	ASTM D638
Tensile Elongation ² (Break)	100	%	ASTM D638
Flexural Modulus ³	1550	MPa	ASTM D790
Flexural Strength ⁴	40.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	kJ/m²	DIN 53453
Charpy Unnotched Impact Strength			DIN 53453
-40°C	No Break		
23°C	No Break		
Notched Izod Impact			

-40°C, 3.20 mm	75	J/m	ISO 180/4A
-20°C, 3.20 mm	80	J/m	ISO 180/4A
0°C, 3.20 mm	90	J/m	ISO 180/4A
23°C, 3.20 mm	110	J/m	ISO 180/4A
-40°C ⁵	7.0	kJ/m ²	ISO 180/1A
23°C ⁶	9.5	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Annealed)	101	°C	ASTM D648
Vicat Softening Temperature			
--	106	°C	ISO 306/A120
--	101	°C	ISO 306/B120
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Thermal Conductivity	0.17	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Electric Strength	30	kV/mm	IEC 60243-1
Dielectric Constant (1 kHz)	3.10		IEC 60250
Dissipation Factor (1 kHz)	0.015		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Glow Wire Ignition Temperature (3.00 mm)	650	°C	IEC 60695-2-13
Additional Information	Nominal Value		
Designation	Thermoplastic ISO 2580-ABS 1,EGN,105-08-09-15		
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 4.0	hr	
Melt Temperature	180 to 220	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		
5.	4 mm		
6.	4 mm		

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