

ASTALOY™ PC/ABS KMB

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS KMB is a flame retardant alloy of ABS and Polycarbonate and is designed to meet the stringent Underwriter's Laboratory UL94 V-0 test whilst offering improved heat resistance (i.e. Ball Indentation Temperature >125°C) and exceptional balance of impact toughness, product rigidity and mouldability.

Typical applications include computer casing mouldings, electrical switchgear assemblies and whitegoods clothes dryer doors.

Note: The letters "U" or "W" indicate additional UV stabilisation [ie: ASTALOY™ PC/ABS KMBU].

General Information	
Additive	Flame Retardant
Features	Flame Retardant
	Good Impact Resistance
	Good Moldability
	High Heat Resistance
	Medium Rigidity
Uses	Electrical/Electronic Applications
	White Goods & Small Appliances

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/3.8 kg	11	g/10 min	
260°C/5.0 kg	24	g/10 min	
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)	119		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)	190	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	85.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	560	J/m	ASTM D256
Gardner Impact (3.20 mm)	75.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	125	°C	

1.8 MPa, Unannealed, 6.40 mm	131	°C	
1.8 MPa, Unannealed, 12.7 mm	137	°C	
Vicat Softening Temperature	151	°C	ASTM D1525 ⁵
CLTE - Flow	7.2E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		UL 94
Glow Wire Ignition Temperature (1.60 mm)	960	°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 260	°C	
Middle Temperature	235 to 270	°C	
Front Temperature	245 to 280	°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	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.	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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