

ASTALAC™ ABS M7

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS M7 is a high impact extrusion grade ABS with moderate flow designed for applications requiring excellent toughness and abuse resistance and good formability.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS M7UV].

General Information			
Features	Good Processability		
	Good Toughness		
	High Impact Resistance		
	Medium Flow		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	6.0	g/10 min	
230°C/3.8 kg	2.0	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)	99		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	40.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	30	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2250	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	69.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	400	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	79.0	°C	
1.8 MPa, Unannealed, 6.40 mm	85.0	°C	
1.8 MPa, Unannealed, 12.7 mm	90.0	°C	
Vicat Softening Temperature	108	°C	ASTM D1525 ⁵
CLTE - Flow	9.0E-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 60695.2.12
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 6.0	hr	
Processing (Melt) Temp	200 to 240	°C	
Back Pressure	10.0 to 25.0	MPa	
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	180 to 200	°C	
Cylinder Zone 2 Temp.	185 to 210	°C	
Cylinder Zone 3 Temp.	190 to 215	°C	
Cylinder Zone 4 Temp.	195 to 220	°C	
Cylinder Zone 5 Temp.	200 to 230	°C	
Die Temperature	200 to 230	°C	
Take-Off Roll	75.0 to 105	°C	
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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