

ASTALAC™ ABS M190

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS M190 is a general purpose ABS injection moulding grade and offers an optimum balance of impact toughness, product rigidity, heat resistance and mouldability. Typical applications include vacuum cleaner casings, electronic consumer goods assemblies, whitegoods fascia panels and handles, coffin fittings and handles as well as telecommunications equipment.
Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS M190UV].

| General Information | | | |
|--------------------------------------------------|------------------------------------|-------------------|-------------|
| Features | General Purpose | | |
| | Good Impact Resistance | | |
| | Good Moldability | | |
| | Medium Heat Resistance | | |
| | Medium Rigidity | | |
| Uses | Electrical/Electronic Applications | | |
| | General Purpose | | |
| | Handles | | |
| | Telecommunications | | |
| | White Goods & Small Appliances | | |
| Processing Method | Injection Molding | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 1.05 | g/cm ³ | ASTM D792 |
| Melt Mass-Flow Rate (MFR) | | | ASTM D1238 |
| 220°C/10.0 kg | 19 | g/10 min | |
| 230°C/3.8 kg | 5.0 | 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) | 102 | | ASTM D785 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Strength ¹ (3.20 mm) | 41.0 | MPa | ASTM D638 |
| Tensile Elongation ² (Break, 3.20 mm) | 55 | % | ASTM D638 |
| Flexural Modulus ³ (3.20 mm) | 2250 | MPa | ASTM D790 |
| Flexural Strength ⁴ (3.20 mm) | 71.0 | MPa | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (3.20 mm) | 280 | J/m | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load | | | ASTM D648 |

| 1.8 MPa, Unannealed, 3.20 mm | 77.0 | °C | |
|------------------------------------------|------------------|--------------------|-------------------------|
| 1.8 MPa, Unannealed, 6.40 mm | 83.0 | °C | |
| 1.8 MPa, Unannealed, 12.7 mm | 88.0 | °C | |
| Vicat Softening Temperature | 102 | °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 |
| Injection | Nominal Value | Unit | |
| Drying Temperature | 85.0 to 90.0 | °C | |
| Drying Time | 3.0 to 6.0 | hr | |
| Rear Temperature | 205 to 225 | °C | |
| Middle Temperature | 215 to 235 | °C | |
| Front Temperature | 225 to 245 | °C | |
| Processing (Melt) Temp | 220 to 250 | °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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

