

ASTALAC™ ABS DM

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS DM is a versatile ABS general purpose injection moulding grade which offers an optimum balance of impact toughness, product rigidity, heat resistance and mouldability. Typical applications include electronic appliance casings and assemblies, refrigerator whitegoods fascia panels, inner shelving systems, lower cooling gratings and outer coloured doorhandles.

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

General Information			
Features	General Purpose		
	Good Impact Resistance		
	Good Moldability		
	Medium Heat Resistance		
	Medium Rigidity		
Uses	General Purpose		
	Handles		
	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) (230°C/3.8 kg)	9.0	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)	103		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)	50	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2250	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	70.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	250	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	87.0	°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 60695.2.12
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 6.0	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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