

ASTALOY™ PC/ABS KMA

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS KMA 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 and an 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 KMAU].

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	1.26	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/3.8 kg	10	g/10 min	
260°C/5.0 kg	19	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)	116		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	57.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	84.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	630	J/m	ASTM D256
Gardner Impact (3.20 mm)	60.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	107	°C	
1.8 MPa, Unannealed, 6.40 mm	113	°C	

1.8 MPa, Unannealed, 12.7 mm	118	°C	
Vicat Softening Temperature	138	°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 245	°C	
Middle Temperature	235 to 255	°C	
Front Temperature	245 to 265	°C	
Processing (Melt) Temp	240 to 270	°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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