

# ASTALOY™ PC/ABS M130GF10

Polycarbonate + ABS  
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/ABS M130GF10 is a high melt flow 10% glass filled alloy of ABS and Polycarbonate and is designed for long flow path injection moulding applications requiring a balance of product rigidity, product toughness, high heat and creep resistance with a minimal expansion of moulded product under heating. Typical applications include automotive instrument panel retainer assemblies and painted exterior body panels.

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Features	Good Creep Resistance		
	Good Toughness		
	High Flow		
	High Heat Resistance		
	Medium Rigidity		
	Paintable		
Uses	Automotive Applications		
	Automotive Exterior Parts		
	Automotive Instrument Panel		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/3.8 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.40	%	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup> (3.20 mm)	56.0	MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break, 3.20 mm)	8.0	%	ASTM D638
Flexural Modulus <sup>3</sup> (3.20 mm)	3300	MPa	ASTM D790
Flexural Strength <sup>4</sup> (3.20 mm)	90.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	103	°C	
1.8 MPa, Unannealed, 6.40 mm	107	°C	
1.8 MPa, Unannealed, 12.7 mm	112	°C	

Vicat Softening Temperature	132	°C	ASTM D1525 <sup>5</sup>
CLTE - Flow	3.9E-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	95.0 to 100	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	235 to 255	°C	
Middle Temperature	245 to 265	°C	
Front Temperature	255 to 275	°C	
Processing (Melt) Temp	250 to 280	°C	
Mold Temperature	50.0 to 90.0	°C	
Injection Pressure	60.0 to 140	MPa	
Injection Rate	Slow-Moderate		
Back Pressure	0.100 to 0.500	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	4.0 to 8.0	kN/cm <sup>2</sup>	
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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