

ASTALLOY™ PC/ABS M130E

Polycarbonate + ABS
Marplex Australia Pty. Ltd.

Message:

ASTALLOY™ PC/ABS M130E is high impact alloy of Polycarbonate and ABS which is designed for extrusion applications requiring balance of impact toughness, heat resistance and processability. It is the sheet extrusion and thermoforming version of ASTALLOY™ PC/ABS M130.
Note: The letters "U" or "W" indicate additional UV stabilisation [ie: ASTALLOY™ PC/ABS M130EU].

General Information			
Features	Good Impact Resistance		
	Good Processability		
	Medium Heat Resistance		
Uses	Sheet		
Processing Method	Sheet Extrusion		
	Thermoforming		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	7.0	g/10 min	
250°C/3.8 kg	4.0	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)	109		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	51.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	150	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	81.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	650	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	98.0	°C	
1.8 MPa, Unannealed, 6.40 mm	103	°C	
1.8 MPa, Unannealed, 12.7 mm	110	°C	
Vicat Softening Temperature	132	°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)	HB		UL 94
Glow Wire Ignition Temperature (1.60 mm)	550	°C	AS/NZS 60695.2.12
Additional Information	Nominal Value		
Screen Mesh - Screen Pack ⁶	20.0 to 40.0		
Screw Cooling	Optional		
Extrusion	Nominal Value	Unit	
Drying Temperature	95.0 to 100	°C	
Drying Time	3.0 to 5.0	hr	
Cylinder Zone 1 Temp.	190 to 210	°C	
Cylinder Zone 2 Temp.	200 to 220	°C	
Cylinder Zone 3 Temp.	210 to 230	°C	
Cylinder Zone 4 Temp.	220 to 240	°C	
Cylinder Zone 5 Temp.	230 to 250	°C	
Melt Temperature	220 to 250	°C	
Die Temperature	220 to 250	°C	
Take-Off Roll	100 to 125	°C	
Back Pressure	10.0 to 25.0	MPa	
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)		
6.	Front to Rear		

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Recommended distributors for this material

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

