

**Excelloy AK10 (AK101)**

(ABS+PA\*)

Techno-UMG Co., Ltd.

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	<b>35</b>	g/10min	ISO 1133
Temperature	<b>260</b>	°C	-
Load	<b>10</b>	kg	-
Molding shrinkage, parallel	<b>0.6 / *</b>	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Strength	<b>50 / 39</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>2090 / 1610</b>	MPa	ISO 178
Flexural strength	<b>75 / 55</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>11 / 24</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Rockwell hardness	<b>R 109</b>	-	ISO 2039-2

<b>ASTM Data</b>			
Tensile Strength	<b>52 / 10.2</b>	MPa	ASTM D 638
Flexural Modulus	<b>2500 / 1960</b>	MPa	ASTM D 790
Flexural Strength	<b>84.3 / 63.7</b>	MPa	ASTM D 790
Rockwell Hardness	<b>R 110 / R 101</b>	-	ASTM D 785

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1050 / -</b>	kg/m <sup>3</sup>	ISO 1183
Density	<b>1050</b>	kg/m <sup>3</sup>	ASTM D 792

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>80 - 90</b>	°C	-
Pre-drying - Time	<b>2 - 5</b>	h	-
Mold temperature	<b>40 - 80</b>	°C	-
Zone 1	<b>240 - 280</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Asia Pacific

**Chemical Resistance**

General Chemical Resistance