

ASTALAC™ ABS M22

ABS

IXOM Operations Pty Ltd

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	19	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	41	MPa	ASTM D 638
Elongation at Break	40	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	68	MPa	ASTM D 790
Rockwell Hardness	R 102	-	ASTM D 785
Izod Impact notched, 1/8 in	350	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.6	mm	-
Coefficient of Thermal Expansion, MD	90	E-6/K	ASTM D 696
DTUL @ 264 psi	76	°C	ASTM D 648
Vicat Temperature	104	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.25	%	ASTM D 570
Density	1040	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	85 - 90	°C	-
Pre-drying - Time	3 - 6	h	-
Melt temperature	220 - 250	°C	-
Mold temperature	40 - 70	°C	-
Zone 1	205 - 225	°C	-
Zone 2	215 - 235	°C	-
Zone 3	225 - 245	°C	-
Screw speed	40 - 60	rpm	-
Injection pressure	60 - 140	MPa	-
Back pressure	0.1 - 0.5	MPa	-

Characteristics**Processing**

Injection Molding

Features

Thermal Stability

Delivery form

Pellets

Applications

Electrical and Electronical

Special Characteristics

High impact or impact modified

Regional Availability

Asia Pacific