

**ASTALOY™ PC/ABS EHA**

(PC+ABS)

IXOM Operations Pty Ltd

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>7</b>	g/10min	ASTM D 1238
Temperature	<b>250</b>	°C	-
Load	<b>3.8</b>	kg	-
Mold Shrinkage, MD	<b>0.006</b>	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength	<b>51</b>	MPa	ASTM D 638
Elongation at Break	<b>100</b>	%	ASTM D 638
Flexural Modulus	<b>2450</b>	MPa	ASTM D 790
Flexural Strength	<b>88</b>	MPa	ASTM D 790
Rockwell Hardness	<b>R 113</b>	-	ASTM D 785
Izod Impact notched, 1/8 in	<b>500</b>	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	<b>HB</b>	-	UL 94
Thickness tested	<b>1.6</b>	mm	-
Coefficient of Thermal Expansion, MD	<b>70</b>	E-6/K	ASTM D 696
DTUL @ 264 psi	<b>96</b>	°C	ASTM D 648
Vicat Temperature	<b>125</b>	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	<b>0.15</b>	%	ASTM D 570
Density	<b>1090</b>	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>95 - 100</b>	°C	-
Pre-drying - Time	<b>3 - 6</b>	h	-
Melt temperature	<b>240 - 290</b>	°C	-
Mold temperature	<b>60 - 100</b>	°C	-
Zone 1	<b>225 - 265</b>	°C	-
Zone 2	<b>235 - 275</b>	°C	-
Zone 3	<b>245 - 285</b>	°C	-
Screw speed	<b>40 - 60</b>	rpm	-
Back pressure	<b>0.1 - 0.5</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Features**

Thermal Stability

**Delivery form**

Pellets

**Applications**

Automotive

**Special Characteristics**

Platable

**Regional Availability**

Asia Pacific