ASTALAC™ ABS M22UV

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/m³	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, U.V. stabilized or stable to weather

Regional Availability
Asia Pacific