

Excelloy AK12G20 (AK602G20)

(ABS+PA*)-GX20

Techno-UMG Co., Ltd.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Melt flow index, MFI	38	g/10min	ISO 1133
Temperature	260	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Strength	97 / 82	MPa	ISO 527
Flexural modulus, 23°C	4750 / 3390	MPa	ISO 178
Flexural strength	167 / 117	MPa	ISO 178
Charpy impact strength, +23°C	15 / 28	kJ/m ²	ISO 179/1eU
Rockwell hardness	R 115	-	ISO 2039-2

ASTM Data			
Tensile Strength	103 / 89.2	MPa	ASTM D 638
Flexural Modulus	5100 / 3510	MPa	ASTM D 790
Flexural Strength	157 / 118	MPa	ASTM D 790
Rockwell Hardness	R 116 / R 112	-	ASTM D 785

Other properties	dry / cond	Unit	Test Standard
Density	1220 / -	kg/m ³	ISO 1183
Density	1220	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	2 - 5	h	-
Mold temperature	50 - 100	°C	-
Zone 1	240 - 280	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Asia Pacific