

**ASTALOY™ PC/ABS TWG**

(PC+ABS)

IXOM Operations Pty Ltd

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	4.6	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength	51	MPa	ASTM D 638
Elongation at Break	70	%	ASTM D 638
Flexural Modulus	2630	MPa	ASTM D 790
Flexural Strength	90	MPa	ASTM D 790
Rockwell Hardness	R 116	-	ASTM D 785
Izod Impact notched, 1/8 in	510	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.6	mm	-
Coefficient of Thermal Expansion, MD	72	E-6/K	ASTM D 696
DTUL @ 264 psi	102	°C	ASTM D 648
Vicat Temperature	135	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.25	%	ASTM D 570
Density	1120	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	95 - 100	°C	-
Pre-drying - Time	3 - 5	h	-
Melt temperature	250 - 280	°C	-
Mold temperature	50 - 90	°C	-
Zone 1	235 - 255	°C	-
Zone 2	245 - 265	°C	-
Zone 3	255 - 275	°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, Weldable

**Delivery form**

Pellets

**Applications**

Automotive

**Special Characteristics**

High impact or impact modified

**Regional Availability**

Asia Pacific