

ASTALOY™ PC/ABS KMX

ASTALOY™ PC/ABS KMX is a flame retardant alloy of ABS and Polycarbonate and is designed to meet the stringent Underwriter's Laboratory UL94 V-0 test whilst offering an exceptional balance of impact toughness, product rigidity, heat resistance and mouldability. Typical applications include computer casing mouldings, electrical switchgear assemblies and whitegoods clothes dryer doors.

Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALOY™ PC/ABS KMXU].

	CONDITIONS	UNITS	TYPICAL VALUES	TESTING METHODS
1. Mechanical Properties				
Notched Izod Impact Strength	12.7 mm x 3.2 mm	J/m	400	ASTM D256
Falling Dart Impact Strength	3.2 mm plaque	J	45	ASTM D3029
Tensile Strength	12.7 mm x 3.2 mm @ 5.0 mm/min	MPa	53	ASTM D638
Elongation to Fail	12.7 mm x 3.2 mm @ 5.0 mm/min	%	60	ASTM D638
Flexural Strength	12.7 mm x 3.2 mm @ 1.3 mm/min	MPa	86	ASTM D790
Flexural Modulus	12.7 mm x 3.2 mm @ 1.3 mm/min	MPa	2400	ASTM D790
2. Thermal Properties				
Heat Deflection Temperature	12.7 mm x 12.7 mm @ 1.82 Mpa	°C	111	ASTM D648
	12.7 mm x 6.4 mm @ 1.82 Mpa	°C	105	ASTM D648
	12.7 mm x 3.2 mm @ 1.82 MPa	°C	98	ASTM D648
VICAT Softening Temperature	1 kg	°C	134	ASTM D1525
Coefficient of Linear Thermal Expansion		cm/cm/°C	7.20E-05	ASTM D696
3. Flammability Properties				
UL Flammability	1.6 mm	Rating	V-0	UL 94
Glow Wire Temperature	1.6 mm	°C	960	AS/NZS 60695
Oxygen Index	Ambient Temperature	-	31	ISO 4589-2
				AS/NZS2122.2
4. Physical Properties				
Melt Flow Rate	230°C, 3.8 kg	g/10 min	2.5	ASTM D1238
	250°C, 3.8 kg	g/10 min	-	ASTM D1238
Specific Gravity		-	1.22	ASTM D792
Rockwell Hardness	R Scale	R	114	ASTM D785
Water Absorption	24 hours	%	0.25	ASTM D570
Mould Shrinkage	3.0 mm plaque	%	0.60	ASTM D955

All test results were obtained using uncoloured material.

Underwriters Laboratory Reference E183535-C.

Issued: March 2011

Material Safety Data Sheet (MSDS) Code: 17315

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TYPICAL PROCESSING CONDITIONS

ASTALOY™ PC/ABS KMX

The following typical guidelines are offered as initial processing conditions for ASTALOY™ PC/ABS KMX. In practice, processing parameters may need to be varied to give commercially acceptable performance in conjunction with optimum physical properties. For specific technical advice on part design or processing conditions, contact the Marplex Technical Service Department.

Temperature of pellet bed in dehumidifying drier		95 - 100°C
Minimum drying time at desired pellet bed temp		3 - 5 hours
Mould temperature		50 - 90°C
Nozzle temperature		Do not exceed stock temperature
Melt temperature		235 - 245°C
Cylinder temperatures	Rear	225 - 240°C
	Middle	230 - 245°C
	Front	235 - 250°C
Fill speed		Medium
Screw speed		40 - 60 rpm
Screw back pressure		0.1 - 0.5 MPa
Injection pressure		60 - 140 MPa
Clamp pressure		4 - 8 kN/cm ²

Comments:

01. Cleanliness of the dryer, machine hopper and machine screw/barrel/nozzle assembly are essential for processing ASTALOY™ PC/ABS alloy and producing contamination free moulded components.
02. ASTALOY™ PC/ABS alloys are not compatible during moulding with other polymers - this also includes ASTALAC™ ABS.
03. It is suggested that the pre-drying, moulding die and material temperatures are manually confirmed using a hand held temperature measuring device.

Conversions:

1 MPa = 145psi
1 MPa = 10.2kg/cm²
1 MPa = 10 bar
°C = 5(°F-32)/9
1 kN/cm² = 0.85 ton/in²