

IXOM OPERATIONS PTY LTD

ACN 600 546 512



ASTALOY™

PC/ABS ALLOY ENGINEERING THERMOPLASTIC

ASTALOY™ IS A REGISTRED TRADEMARK OF MARPLEX AUSTRALIA PTY. LTD.

ASTALOY™ PC/ABS EHA

ASTALOY™ PC/ABS EHA is an electroplatable alloy of Polycarbonate & ABS which is designed for injection moulding applications requiring a balance of easy electoplatability, impact toughness, product rigidity, heat resistance and mouldability. Typical applications in the automotive field include electroplated grilles, garnishes and doorhandles.

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

	CONDITIONS	_	<u> </u>	TESTING METHODS
1. Mechanical Properties				
Notched Izod Impact Strength	12.7 mm x 3.2 mm	J/m	500	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	51	ASTM D638
Elongation to Fail	12.7 mm x 3.2 mm @ 5.0 mm/min	%	100	ASTM D638
Flexural Strength	12.7 mm x 3.2 mm @ 1.3 mm/min	MPa	88	ASTM D790
Flexural Modulus	12.7 mm x 3.2 mm @ 1.3 mm/min	MPa	2450	ASTM D790
2. Thermal Properties				
Heat Deflection Temperature	12.7 mm x 12.7 mm @ 1.82 Mpa	°C	106	ASTM D648
	12.7 mm x 6.4 mm @ 1.82 Mpa	°C	101	ASTM D648
	12.7 mm x 3.2 mm @ 1.82 MPa	°C	96	ASTM D648
VICAT Softening Temperature	1 kg	°C	125	ASTM D1525
Coefficient of Linear Thermal Expansion		cm/cm/°C	7.00E-05	ASTM D696
3. Flammability Properties				
UL Flammability	1.6 mm	Rating	HB	UL 94
Glow Wire Temperature	1.6 mm	°C	550	AS/NZS 60695
4. Physical Properties				
Melt Flow Rate	250°C, 3.8 kg	g/10 min	7.0	ASTM D1238
	260°C, 5.0 kg	g/10 min	17	ASTM D1238
Specific Gravity		-	1.09	ASTM D792
Rockwell Hardness	R Scale	R	113	ASTM D785
Water Absorption	24 hours	%	0.15	ASTM D570
Mould Shrinkage	3.0 mm plaque	%	0.60	ASTM D955

All test results were obtained using uncoloured material.

Material Safety Data Sheet (MSDS): Code 17314

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IXOM OPERATIONS PTY LTD 1 NICHOLSON ST, EAST MELBOURNE, VIC. 3002 AUSTRALIA

PH: 1300 550 036 FAX: 1300 550 081 ixom.com

CUSTOMER SERVICE: PH: 1300 557 862 marplex.com.au MARPLEX AUSTRALIA PTY LTD 165 FITZGERALD RD, LAVERTON NORTH, VIC. 3026 AUSTRALIA

24 HR EMERGENCY • AU 1800 033 111 • NZ 0800 734 607 • INTERNATIONAL +61 3 9663 2130

TYPICAL PROCESSING CONDITIONS

ASTALOY™ PC/ABS EHA

The following typical guidelines are offered as initial processing conditions for ASTALOY™ PC/ABS EHA 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 - 6 hours

Mould temperature 60 - 100°C

Nozzle temperature Do not exceed stock temperature

Melt temperature 240 - 290°C

Cylinder temperatures Rear 225 - 265°C

Middle 235 - 275°C

Front 245 - 285°C

Fill speed Slow

Screw speed 40 - 60 rpm

Screw back pressure 0.1 - 0.5 MPa

Injection pressure Minimum

Clamp pressure 4 - 8 kN/cm²

Comment(s):

- 1 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.
- 2 ASTALOY™ PC/ABS alloys are not compatible during moulding with other polymers this also includes ASTALAC™ ABS.
- 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 = 145 psi

= 10.2 kg/cm²

= 10 bar

 $^{\circ}C = 5(F-32)/9$

 $1 \text{ kN/cm}^2 = 0.65 \text{ ton/in}^2$