

Technical Data Sheet



ALTECH PC+ASA A 1000/506

Base Polymer	Polycarbonate +Acrylonitrile Styrene Acrylate Blend
Special Features	easy release (demoulding), injection moulding grade
Market Segment	Automotive
Application Area	interior decoration / finishing

Pre-Drying Conditions	in a dry air (dessiccant) dryer 90-110 °C for 2-4 h in an air circulating dryer 90-110 °C for 3-6 h dependant on moisture content max. moisture content <0,02 %
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Processing Injection Moulding	melt temperature 260-300 °C mould temperature 60-100 °C
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Storage	dry, protected from light
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Properties	Value	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	2600	MPa	ISO 178
Flexural Stress (3.5% Strain)	78	MPa	ISO 178
Tensile Modulus	2500	MPa	ISO 527
Tensile Stress at Yield	62	MPa	ISO 527
Tensile Elongation at Yield	5	%	ISO 527
Tensile Elongation at Break	65	%	ISO 527
Impact Strength (Charpy, 23°C)	no break	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	no break	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	55	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	13	kJ/m ²	ISO 179/1eA
Ball Indentation Hardness H358/30	115	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	132	°C	ISO 306
HDT / A (1,8 MPa)	115	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	20	cm ³ /10min	ISO 1133
MVR temperature	260	°C	-
MVR load	5	kg	-
Shrinkage (24h)	0.6 - 0.8	%	ISO 294-4
Physical Properties			
Density	1190	kg/m ³	ISO 1183