

ALTECH ABS+PMMA A 1000/500

(Last update: 25.05.2022)

MOCOM

Base Polymer	Polymethylmethacrylate,Acrylonitrile/Butadiene/Styrene/Copolymer
Service Temperature	max. range (depending on load, geometry, etc.) -40-85 °C
Special Features	processing stabilised,scratch resistant
Market Segment	various
Application Area	injection moulded parts
Typical Applications	various,clothing / fasteners,bezels

Pre-Drying Conditions	in a dry air (dessiccant) dryer 65-90 °C for 3-4 h in an air circulating dryer 65-90 °C for 4-6 h dependant on moisture content max. moisture content <0,02 %
Processing Injection Moulding	melt temperature 220-260 °C mould temperature 50-80 °C
Storage	dry, protected from light
Minimum Shelf Life	24 months

Properties	Value	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	2750	MPa	ISO 178
Flexural Stress (3.5% Strain)	75	MPa	ISO 178
Tensile Modulus	2600	MPa	ISO 527
Tensile Stress at Yield	52	MPa	ISO 527
Tensile Elongation at Yield	2.5	%	ISO 527
Tensile Elongation at Break	22	%	ISO 527
Impact Strength (Charpy, 23°C)	48	kJ/m²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	45	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	7	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	3	kJ/m²	ISO 179/1eA
Ball Indentation Hardness H358/30	125	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	95	°C	ISO 306
HDT / A (1,8 MPa)	81	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	25	cm³/10min	ISO 1133
MVR temperature	220	°C	-
MVR load	10	kg	-
Shrinkage (24h)	0.5 - 0.8	%	ISO 294-4



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Physical Properties

Density	1100	kg/m ³	ISO 1183
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Liability Exclusion

These are guide values and not a specification. The test values mentioned are representative values only and not binding minimum or maximum figures. These test values have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions.

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