

Technical Data Sheet



ALTECH ABS A 2015/506 GF15

Base Polymer	Acrylonitrile/Butadiene/Styrene/Copolymer
Filler/Additive System	15 % glass fibres
Special Features	injection moulding grade, processing stabilised
Application Area	various, injection moulded parts

Pre-Drying Conditions	80 °C in a dry air (dessiccant) dryer for 2-4 h 80 °C in an air circulating dryer for 3-6 h dependant on moisture content max. moisture content <0,20 %
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Processing Injection Moulding	melt temperature 220-260 °C mould temperature 50-80 °C
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Storage	dry, protected from light
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Properties	Value	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	4500	MPa	ISO 178
Flexural Strength	88	MPa	ISO 178
Tensile Modulus	4900	MPa	ISO 527
Tensile Strength at Break	60	MPa	ISO 527
Tensile Elongation at Break	1.7	%	ISO 527
Impact Strength (Charpy, 23°C)	18	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	15	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	7	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	5	kJ/m ²	ISO 179/1eA
Ball Indentation Hardness H358/30	120	MPa	ISO 2039-1
Thermal Properties			
Vicat B50	102	°C	ISO 306
HDT / A (1,8 MPa)	102	°C	ISO 75-1/-2
Rheological Properties			
Melt Index (MVR)	8	cm ³ /10min	ISO 1133
MVR temperature	220	°C	-
MVR load	10	kg	-
Shrinkage (lengthwise, 24h)	0.1 - 0.3	%	ISO 294-4
Shrinkage (lateral, 24h)	0.1 - 0.3	%	ISO 294-4
Physical Properties			
Density	1140	kg/m ³	ISO 1183