

Technical Data Sheet



ALTECH ABS+PMMA A 1000/500

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
Physical Properties			
Density	1100	kg/m³	ISO 1183