Technical Data Sheet

Polylux MABS C2 KU BUA49355

Methyl Methacrylate / ABS

Product Description
good flow transparent MABS grade

Processing Method	Injection Molding
Appearance	Clear/Transparent
Resin ID	MABS

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (220 °C/10.0 kg)	18	cm³/10 min	ISO 1133
Density, (Method A)	1.09	g/cm³	ISO 1183
Mechanical			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	44.0	MPa	ISO 527-2
Tensile Strain at Yield, (Type 1A, 50 mm/min)	3.5	%	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	1900	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	16	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	9.0	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	79	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	62	kJ/m²	ISO 179
Notched Izod Impact Strength, (23 °C, Type 4, Notch A)	17	kJ/m²	ISO 180
Hardness			
Ball Indentation Hardness, (H 358/30)	96.0	MPa	ISO 2039-1
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	93.0	°C	ISO 306
(A (10N), 50 °C/h)	103	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	92.0	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	79.0	°C	ISO 75-2/A
Flammable			
Burning Rate			
(2.00 mm)	<100	mm/min	FMVSS 302
(2.00 mm)	<100	mm/min	ISO 3795

Glow Wire Flammability Index			
(1.5 mm)	675	°C	IEC 60695-2-12
(3.0 mm)	675	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			
(1.5 mm)	700	°C	IEC 60695-2-13
(3.0 mm)	700	°C	IEC 60695-2-13
UL Information			
Flammability Classification, (1.6 mm)	HB		IEC 60695-11-10, -20

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	70	°C
Processing (Melt) Temp	200 to 240	°C
Mold Temperature	40 to 80	°C