

Romiloy® 6040 E UV

Acrylonitrile Styrene Acrylate + PC

ROMIRA GmbH

Message:

Romiloy® 6040 E UV is an acrylonitrile-styrene-acrylate PC (ASA PC) material. This product is available in Europe and is processed by extrusion or injection molding.

Romiloy® The main characteristics of 6040 E UV are:

flame retardant/rated flame

Good UV resistance

UV stability

General Information			
Additive	UV stabilizer		
Features	Good UV resistance		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ISO 1133
220°C/10.0 kg	6.0	g/10 min	ISO 1133
260°C/5.0 kg	14	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 - 0.70	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2600	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	60.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	100	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2500	MPa	ISO 178
Flexural Stress ² (23°C)	95.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	20	kJ/m ²	ISO 179/1eA
23°C	55	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	123	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	8.5E-5	cm/cm/°C	ISO 11359-2

Flammability	Nominal Value	Test Method
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Flame Rating (1.50 mm)	HB	UL 94
Additional Information		
The value listed as Molding Shrinkage ISO 294-4, was tested in accordance with DIN 16901.The value listed as Coefficient of Linear Thermal Expansion ISO 11359-1-2, was tested in accordance with DIN 53752.		
Injection	Nominal Value	Unit
Drying Temperature	60.0 - 100	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.050	%
Suggested Max Regrind	5	%
Processing (Melt) Temp	240 - 260	°C
Mold Temperature	60.0 - 100	°C
Injection Rate	Moderate	
Injection instructions		
Back Pressure: <20%Holding Pressure: Low		
Extrusion	Nominal Value	Unit
Drying Temperature	60.0 - 100	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	< 0.050	%
Cylinder Zone 1 Temp.	210 - 250	°C
Cylinder Zone 2 Temp.	210 - 250	°C
Cylinder Zone 3 Temp.	210 - 250	°C
Cylinder Zone 4 Temp.	210 - 250	°C
Cylinder Zone 5 Temp.	210 - 250	°C
Melt Temperature	< 260	°C
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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