

Romiloy® 6040

Acrylonitrile Styrene Acrylate + PC

ROMIRA GmbH

Message:

Romiloy® 6040 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 the 6040 are: flame retardant/rated flame.

General Information			
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) (260°C/5.0 kg)	35	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)	2500	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	60.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	60	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2400	MPa	ISO 178
Flexural Stress ² (23°C)	93.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	40	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	119	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	8.5E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating	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	80.0 - 100	°C
Drying Time	2.0 - 4.0	hr
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	

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

