

KumhoSunny ASA XC200

Acrylonitrile Styrene Acrylate
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
ASAXC811 is a type of general ASA resin, with excellent weatherability and high flow .

General Information			
Features	General Purpose		
	Good Weather Resistance		
	High Flow		
Uses	Consumer Applications		
	Electrical/Electronic Applications		
	General Purpose		
	Household Goods		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
220°C/10.0 kg	20	g/10 min	ASTM D1238
220°C/10.0 kg	15	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.40 to 0.70	%	ASTM D955
--	0.40 to 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	52.0	MPa	ASTM D638
--	50.0	MPa	ISO 527-2/50
Tensile Elongation			
Break	25	%	ASTM D638
Break	20	%	ISO 527-2/50
Flexural Modulus			
--	2200	MPa	ASTM D790

-- ¹	2400	MPa	ISO 178
Flexural Strength			
--	72.0	MPa	ASTM D790
-- ²	68.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	6.0	kJ/m ²	
23°C	14	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)	70	kJ/m ²	ISO 179
Notched Izod Impact			
3.20 mm	170	J/m	ASTM D256
23°C ⁵	13	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	84.0	°C	ASTM D648
1.8 MPa, Unannealed ⁶	86.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	94.0	°C	ASTM D1525 ⁷
--	96.0	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+14	ohms	IEC 60093
Volume Resistivity	> 1.0E+14	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	190 to 210	°C	
Middle Temperature	210 to 220	°C	
Front Temperature	225 to 235	°C	
Nozzle Temperature	220 to 230	°C	
Processing (Melt) Temp	220 to 230	°C	
Mold Temperature	50.0 to 80.0	°C	
Back Pressure	1.00 to 5.00	MPa	
Screw Speed	30 to 70	rpm	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	4J		
4.	4J		

5.	5.5J
6.	120°C/h
7.	Rate B (120°C/h)

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