

ASTALAC™ ASA 306

Acrylonitrile Styrene Acrylate
Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ASA 306 is a high impact strength grade of ASA suitable for both extrusion and injection moulding applications requiring a combination of impact toughness, abuse resistance, product rigidity and processability. ASA grades show superior colour and property retention compared to ABS. Typical thermoformed applications include advertising signage blanks and caravan panels. Typical injection moulding applications include protective housings for exterior use.

Note: The letters "UV" or "W" indicate additional UV stabilisation [ie: ASTALAC™ ASA 306UV].

General Information			
Features	Good Color Stability		
	Good Processability		
	High Impact Resistance		
	Medium Rigidity		
Uses	Housings		
	Reinforced Panels		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	92		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	38.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	70	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2050	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	62.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	430	J/m	ASTM D256
Gardner Impact (3.20 mm)	30.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	77.0	°C	
1.8 MPa, Unannealed, 12.7 mm	87.0	°C	

Vicat Softening Temperature	103	°C	ASTM D1525 ⁵
CLTE - Flow	9.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Ignition Temperature (1.60 mm)	550	°C	AS/NZS 60695.2.12
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 6.0	hr	
Processing (Melt) Temp	190 to 230	°C	
Back Pressure	10.0 to 25.0	MPa	
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	170 to 190	°C	
Cylinder Zone 2 Temp.	175 to 200	°C	
Cylinder Zone 3 Temp.	180 to 205	°C	
Cylinder Zone 4 Temp.	185 to 210	°C	
Cylinder Zone 5 Temp.	190 to 220	°C	
Die Temperature	180 to 220	°C	
Take-Off Roll	75.0 to 105	°C	
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	Loading 1 (10 N)		

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