

# LG ASA LI923P

Acrylonitrile Styrene Acrylate

LG Chem Ltd.

## Message:

Description  
Good Weatherability, High Stiffness, Good Processibility  
Application  
Deco sheet, Profile

| General Information                                              |                         |                   |             |
|------------------------------------------------------------------|-------------------------|-------------------|-------------|
| Features                                                         | Rigidity, high          |                   |             |
|                                                                  | Workability, good       |                   |             |
|                                                                  | Good weather resistance |                   |             |
| Uses                                                             | Sheet                   |                   |             |
|                                                                  | Profile                 |                   |             |
| Processing Method                                                | Extrusion               |                   |             |
| Physical                                                         | Nominal Value           | Unit              | Test Method |
| Specific Gravity                                                 | 1.07                    | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)                        | 8.0                     | g/10 min          | ASTM D1238  |
| Molding Shrinkage - Flow (3.20 mm)                               | 0.40 - 0.70             | %                 | ASTM D955   |
| Hardness                                                         | Nominal Value           | Unit              | Test Method |
| Rockwell Hardness (R-Scale)                                      | 106                     |                   | ASTM D785   |
| Mechanical                                                       | Nominal Value           | Unit              | Test Method |
| Tensile Strength <sup>1</sup> (Yield, 3.20 mm)                   | 51.0                    | MPa               | ASTM D638   |
| Tensile Elongation <sup>2</sup>                                  |                         |                   | ASTM D638   |
| Yield, 3.20mm                                                    | > 6.0                   | %                 | ASTM D638   |
| Fracture, 3.20mm                                                 | 30                      | %                 | ASTM D638   |
| Flexural Modulus <sup>3</sup> (3.20 mm)                          | 24000                   | MPa               | ASTM D790   |
| Flexural Strength <sup>4</sup> (3.20 mm)                         | 83.4                    | MPa               | ASTM D790   |
| Impact                                                           | Nominal Value           | Unit              | Test Method |
| Notched Izod Impact                                              |                         |                   | ASTM D256   |
| -30°C, 3.20 mm                                                   | 20                      | J/m               | ASTM D256   |
| -30°C, 6.40 mm                                                   | 20                      | J/m               | ASTM D256   |
| 23°C, 3.20 mm                                                    | 49                      | J/m               | ASTM D256   |
| 23°C, 6.40 mm                                                    | 59                      | J/m               | ASTM D256   |
| Thermal                                                          | Nominal Value           | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm) | 86.0                    | °C                | ASTM D648   |
| Flammability                                                     | Nominal Value           |                   | Test Method |

| Flame Rating                                                                                                                                                     |               | UL 94 |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|-------|
| 1.6 mm                                                                                                                                                           | HB            | UL 94 |
| 3.2 mm                                                                                                                                                           | HB            | UL 94 |
| Extrusion                                                                                                                                                        | Nominal Value | Unit  |
| Drying Temperature                                                                                                                                               | 80 - 90       | °C    |
| Drying Time                                                                                                                                                      | 2.0 - 3.0     | hr    |
| Cylinder Zone 1 Temp.                                                                                                                                            | 190 - 200     | °C    |
| Cylinder Zone 2 Temp.                                                                                                                                            | 200 - 220     | °C    |
| Cylinder Zone 3 Temp.                                                                                                                                            | 210 - 230     | °C    |
| Cylinder Zone 4 Temp.                                                                                                                                            | 210 - 230     | °C    |
| Adapter Temperature                                                                                                                                              | 210 - 230     | °C    |
| Melt Temperature                                                                                                                                                 | 200 - 230     | °C    |
| Die Temperature                                                                                                                                                  | 210 - 250     | °C    |
| Extrusion instructions                                                                                                                                           |               |       |
| Minimum Moisture Content: 0.01%Roll Stack Temperature, Top: 70 to 90 °C Roll Stack Temperature, Middle: 70 to 90 °C Roll Stack Temperature, Bottom: 70 to 100 °C |               |       |
| NOTE                                                                                                                                                             |               |       |
| 1.                                                                                                                                                               | 50 mm/min     |       |
| 2.                                                                                                                                                               | 50 mm/min     |       |
| 3.                                                                                                                                                               | 15 mm/min     |       |
| 4.                                                                                                                                                               | 15 mm/min     |       |

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