

LG ASA LI912-WNPZ

Acrylonitrile Styrene Acrylate

LG Chem Ltd.

Message:

Description
Excellent Chemical Resistance, High Impact
Application
Bidet, miscellaneous goods, profile

General Information			
Features	Impact resistance, high		
	Good chemical resistance		
Uses	Profile		
Processing Method	Co-extrusion molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	7.5	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)	103		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	39.2	MPa	ASTM D638
Tensile Elongation ²			ASTM D638
Yield, 3.20mm	> 6.0	%	ASTM D638
Fracture, 3.20mm	50	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	1770	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	58.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	250	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
Injection	Nominal Value	Unit	
Drying Temperature	80 - 90	°C	

Drying Time	2.0 - 3.0	hr
Rear Temperature	180 - 200	°C
Middle Temperature	190 - 210	°C
Front Temperature	210 - 220	°C
Nozzle Temperature	210 - 220	°C
Processing (Melt) Temp	200 - 230	°C
Mold Temperature	40 - 80	°C
Back Pressure	0.490 - 0.981	MPa
Screw Speed	50 - 100	rpm

Injection instructions

Minimum Moisture Content: 0.01%

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°CRoll Stack Temperature, Middle: 70 to 90°CRoll 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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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



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