

DIAMALLOY ASAPC GLY 130

Acrylonitrile Styrene Acrylate + PC
Network Polymers, Inc.

Message:

DIAMALLOY ASAPC GLY 130 is an Acrylonitrile Styrene Acrylate + PC (ASA+PC) product. It is available in North America.
Characteristics include:
REACH Compliant
RoHS Compliant
WEEE Compliant
UV Stabilized

General Information			
Additive	UV Stabilizer		
Agency Ratings	EC 1907/2006 (REACH)		
	EU 2002/96/EC (WEEE)		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (265°C/5.0 kg)	35	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	61.4	MPa	ASTM D638
Flexural Modulus ³	2500	MPa	ASTM D790B
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	430	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.35 mm	103	°C	
1.8 MPa, Annealed, 6.35 mm	121	°C	
Vicat Softening Temperature	137	°C	ASTM D1525 ⁴
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.10	%	
Suggested Shot Size	40 to 70	%	
Suggested Max Regrind	30	%	
Rear Temperature	230 to 260	°C	

Middle Temperature	232 to 265	°C
Front Temperature	235 to 272	°C
Nozzle Temperature	220 to 272	°C
Processing (Melt) Temp	220 to 272	°C
Mold Temperature	40.0 to 80.0	°C
Injection Rate	Fast	
Back Pressure	0.517 to 1.03	MPa

NOTE		
1.	Procedure A	
2.	51 mm/min	
3.	Method I (3 point load), 1.3 mm/min	
4.	Loading 1 (10 N)	

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WECHAT