ASTALAC™ ASA 304

Acrylonitrile Styrene Acrylate

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ASA 304 is a medium melt flow ultra high impact grade of ASA which is designed for applications requiring a combination of toughness, mouldability, rigidity and heat resistance. As ASA grades show superior colour and property retention compared to ABS, typical applications include signage, outside building products and automotive exterior components.
Note: The letters "UV" or "W" indicate additional UV stabilisation [ie: ASTALAC™ ASA 304UV].

General Information	
Features	Good Color Stability
	Good Moldability
	Good Toughness
	Medium Flow
	Medium Heat Resistance
	Medium Rigidity
	Ultra High Impact Resistance
Uses	Automotive Applications
	Automotive Exterior Parts

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	12	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)	97		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (3.20 mm)	40.0	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	70	%	ASTM D638
Flexural Modulus [3] (3.20 mm)	2200	MPa	ASTM D790
Flexural Strength [4] (3.20 mm)	68.0	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.20 mm)	450	J/m	ASTM D256
Gardner Impact (3.20 mm)	35.0	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, 6.40 mm	82.0	°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 5.0	hr	
Rear Temperature	205 to 225	°C	
Middle Temperature	215 to 235	°C	
Front Temperature	225 to 245	°C	
Processing (Melt) Temp	220 to 250	°C	
Mold Temperature	40.0 to 70.0	°C	
Injection Pressure	60.0 to 140	MPa	
Injection Rate	Moderate		
Back Pressure	0.100 to 0.500	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	3.0 to 6.0	kN/cm^2	
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)		

Recommended distributors for this material

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