

Romiloy® 6020

Acrylonitrile Styrene Acrylate + PC

ROMIRA GmbH

Message:

Romiloy®6020 is an acrylonitrile-styrene-acrylate PC (ASA PC) material. This product is available in Europe and is processed by extrusion or injection molding. Romiloy®The main characteristics of the 6020 are: flame retardant/rated flame.

General Information			
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.17	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	35	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 - 0.70	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2520	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	64.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	> 80	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2450	MPa	ISO 178
Flexural Stress ² (23°C)	95.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	25	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	105	°C	ISO 75-2/A
Vicat Softening Temperature	130	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	8.0E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	60.0 - 100	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.050	%	
Suggested Max Regrind	5	%	
Processing (Melt) Temp	240 - 260	°C	
Mold Temperature	60.0 - 100	°C	
Injection Rate	Moderate		

Injection instructions		
Back Pressure: <20%Holding Pressure: low		
Extrusion	Nominal Value	Unit
Drying Temperature	80.0 - 100	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	< 0.050	%
Cylinder Zone 1 Temp.	210 - 250	°C
Cylinder Zone 2 Temp.	210 - 250	°C
Cylinder Zone 3 Temp.	210 - 250	°C
Cylinder Zone 4 Temp.	210 - 250	°C
Cylinder Zone 5 Temp.	210 - 250	°C
Melt Temperature	< 260	°C
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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