

Starex WR-9120AT

Acrylonitrile Styrene Acrylate
LOTTE ADVANCED MATERIALS CO., LTD.

Message:
ASA that is applied to washing machine cover etc.

General Information			
UL YellowCard	E115797-219510		
Uses	Electrical appliances		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	15	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	106		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	48.0	MPa	ASTM D638
Tensile Elongation ² (Break)	60	%	ASTM D638
Flexural Modulus ³	2200	MPa	ASTM D790
Flexural Strength ⁴	66.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	82.0	°C	ASTM D648
Vicat Softening Temperature	97.0	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity ⁵	1.0E+11	ohms	ASTM D257
ESD ⁶ (23°C)	3.0	sec	JIS L1049
Injection	Nominal Value	Unit	
Drying Temperature			
--	80 - 90	°C	
Hot air dryer	80	°C	
Drying Time			
--	2.0 - 4.0	hr	
Hot air dryer	2.0 - 3.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	180 - 190	°C	
Middle Temperature	200 - 210	°C	
Front Temperature	220 - 230	°C	
Nozzle Temperature	240	°C	

Mold Temperature	40 - 80	°C
Injection Pressure	49.0 - 245	MPa
Back Pressure	0.490 - 1.96	MPa
Screw Speed	50 - 150	rpm

NOTE		
1.	5.0 mm/min	
2.	5.0 mm/min	
3.	2.8 mm/min	
4.	2.8 mm/min	
5.	at 23°C, 50% RH	
6.	50% RH	

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