

# DIALAC® TW25

Acrylonitrile Styrene Acrylate

UMG ABS, Ltd.

## Message:

DIALAC® TW25 is an Acrylonitrile Styrene Acrylate (ASA) material. It is available in Asia Pacific or North America for injection molding.

Important attributes of DIALAC® TW25 are:

Flame Rated

RoHS Compliant

| General Information                               |                   |                        |             |
|---------------------------------------------------|-------------------|------------------------|-------------|
| UL YellowCard                                     | E47016-237278     |                        |             |
| RoHS Compliance                                   | RoHS Compliant    |                        |             |
| UL File Number                                    | E47016            |                        |             |
| Forms                                             | Pellets           |                        |             |
| Processing Method                                 | Injection Molding |                        |             |
| Physical                                          | Nominal Value     | Unit                   | Test Method |
| Density (23°C)                                    | 1.10              | g/cm <sup>3</sup>      | ISO 1183    |
| Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)       | 3.00              | cm <sup>3</sup> /10min | ISO 1133    |
| Molding Shrinkage - Flow (23°C)                   | 0.50 to 0.70      | %                      | ISO 294-4   |
| Hardness                                          | Nominal Value     | Unit                   | Test Method |
| Rockwell Hardness (R-Scale, 23°C)                 | 108               |                        | ISO 2039-2  |
| Mechanical                                        | Nominal Value     | Unit                   | Test Method |
| Tensile Modulus (23°C)                            | 2100              | MPa                    | ISO 527-2   |
| Tensile Stress (23°C)                             | 48.0              | MPa                    | ISO 527-2   |
| Flexural Modulus <sup>1</sup> (23°C)              | 2300              | MPa                    | ISO 178     |
| Flexural Stress <sup>2</sup> (23°C)               | 75.0              | MPa                    | ISO 178     |
| Impact                                            | Nominal Value     | Unit                   | Test Method |
| Charpy Notched Impact Strength                    |                   |                        | ISO 179     |
| -30°C                                             | 3.0               | kJ/m <sup>2</sup>      |             |
| 23°C                                              | 9.0               | kJ/m <sup>2</sup>      |             |
| Thermal                                           | Nominal Value     | Unit                   | Test Method |
| Heat Deflection Temperature (1.8 MPa, Unannealed) | 100               | °C                     | ISO 75-2/Af |
| CLTE - Flow                                       | 9.0E-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                                | 100               | °C                     |             |
| Drying Time                                       | 3.0 to 4.0        | hr                     |             |
| Rear Temperature                                  | 190 to 210        | °C                     |             |
| Middle Temperature                                | 210 to 230        | °C                     |             |

|                        |              |     |
|------------------------|--------------|-----|
| Front Temperature      | 220 to 250   | °C  |
| Nozzle Temperature     | 200 to 230   | °C  |
| Processing (Melt) Temp | 220 to 260   | °C  |
| Mold Temperature       | 50.0 to 80.0 | °C  |
| Injection Pressure     | 70.0 to 140  | MPa |
| Injection Rate         | Moderate     |     |
| Back Pressure          | 5.00 to 15.0 | MPa |
| Screw Speed            | 50 to 100    | rpm |

#### NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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#### Recommended distributors for this material

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