

LG ASA LI913

Acrylonitrile Styrene Acrylate

LG Chem Ltd.

Message:

Application
Satellite antenna, boat,lamp cover, door frame, electric & electronic components.

Feature
Extrusion ASA from LG chem. Is widely used for satellite antennas and boat components. Owing to the typical properties as follows.

General Information			
UL YellowCard	E67171-248323		
Uses	Electrical/Electronic Applications		
	Outdoor application		
Processing Method	Extrusion		
	Injection molding		
Multi-Point Data	Specific Heat vs. Temperature (ISO 11403-2)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	92		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	1730	MPa	ASTM D638
Tensile Strength ² (Yield, 3.20 mm)	40.2	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield, 3.20mm	> 5.0	%	ASTM D638
Fracture, 3.20mm	35	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	1810	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 3.20 mm)	61.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	59	J/m	ASTM D256
-30°C, 6.40 mm	59	J/m	ASTM D256
23°C, 3.20 mm	440	J/m	ASTM D256
23°C, 6.40 mm	340	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, unannealed, 6.40mm	96.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	86.0	°C	ASTM D648
Vicat Softening Temperature	94.0	°C	ASTM D1525 ⁶
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Suggested Max Moisture	0.010	%	
Cylinder Zone 1 Temp.	190 - 200	°C	
Cylinder Zone 2 Temp.	200 - 220	°C	
Cylinder Zone 3 Temp.	210 - 230	°C	
Cylinder Zone 4 Temp.	210 - 230	°C	
Adapter Temperature	210 - 230	°C	
Melt Temperature	200 - 230	°C	
Die Temperature	210 - 250	°C	
Extrusion instructions			
Roll Stack Temperature - Top: 70 to 90 °C Roll Stack Temperature - Middle: 70 to 90 °C Roll Stack Temperature - Bottom: 70 to 100 °C			
NOTE			
1.	1.0 mm/min		
2.	50 mm/min		
3.	50 mm/min		
4.	15 mm/min		
5.	15 mm/min		
6.	速率 A (50°C/h), 载荷2 (50N)		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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