

Starex WR-9330I

Acrylonitrile Styrene Acrylate
SAMSUNG SDI CO., LTD.

Message:

Starex WR-9330I is an Acrylonitrile Styrene Acrylate (ASA) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Typical application: Automotive.

General Information			
UL YellowCard		E115797-219514	
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.39 to 0.48	%	
Across Flow : 3.20 mm	0.43 to 0.53	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	107		ASTM D785
R-Scale	108		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2100	MPa	ASTM D638
--	2400	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	47.0	MPa	ASTM D638
Yield	52.0	MPa	ISO 527-2/50
Break ³	36.0	MPa	ASTM D638
Break	40.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	17	%	ASTM D638
Break	11	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2300	MPa	ASTM D790
-- ⁶	2600	MPa	ISO 178
Flexural Strength			
-- ⁷	70.0	MPa	ASTM D790
-- ⁸	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	10	kJ/m ²	ISO 179/1eA
Notched Izod Impact			

23°C, 3.18 mm	140	J/m	ASTM D256
23°C, 6.35 mm	59	J/m	ASTM D256
23°C ¹⁰	9.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 4.00 mm	97.0	°C	ISO 75-2/B
0.45 MPa, Annealed	107	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	93.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	82.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	103	°C	ISO 75-2/A
Vicat Softening Temperature			
--	101	°C	ISO 306/B50
--	99.0	°C	ISO 306/B120
Injection	Nominal Value	Unit	
Drying Temperature			
--	80.0 to 90.0	°C	
Desiccant Dryer	80.0	°C	
Drying Time			
--	2.0 to 4.0	hr	
Desiccant Dryer	2.0 to 3.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	180 to 190	°C	
Middle Temperature	200 to 210	°C	
Front Temperature	220 to 230	°C	
Nozzle Temperature	240	°C	
Mold Temperature	40.0 to 80.0	°C	
Injection Pressure	49.0 to 245	MPa	
Back Pressure	0.490 to 1.96	MPa	
Screw Speed	50 to 150	rpm	
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	5.0 mm/min		
4.	5.0 mm/min		
5.	2.8 mm/min		
6.	2.0 mm/min		
7.	2.8 mm/min		
8.	2.0 mm/min		
9.	Thickness: 4 mm		
10.	Thickness: 4 mm		

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