

LG ASA LI911

Acrylonitrile Styrene Acrylate

LG Chem Ltd.

Message:

Description
Good Weatherability, High Flow
Applications
Air-Conditioner grill, sewing machine cover, Electric/Electronic Applications

General Information			
UL YellowCard	E67171-248321		
Features	Good Weather Resistance		
	High Flow		
Uses	Appliance Components		
	Electrical/Electronic Applications		
	Power/Other Tools		
Forms	Pellets		
Processing Method	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)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	107		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	2170	MPa	ASTM D638
Tensile Strength ² (Yield, 3.20 mm)	49.0	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield, 3.20 mm	> 6.0	%	
Break	20	%	
Flexural Modulus ⁴ (3.20 mm)	2300	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 3.20 mm)	78.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	29	J/m	
-30°C, 6.40 mm	29	J/m	
23°C, 3.20 mm	140	J/m	

23°C, 6.40 mm	120	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Annealed, 6.40 mm	96.0	°C	
1.8 MPa, Annealed, 6.40 mm	87.0	°C	
Vicat Softening Temperature	96.0	°C	ASTM D1525 ⁶
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.60 mm	HB		
3.20 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	2.0 to 3.0	hr	
Suggested Max Moisture	> 0.010	%	
Rear Temperature	180 to 200	°C	
Middle Temperature	190 to 210	°C	
Front Temperature	210 to 220	°C	
Nozzle Temperature	210 to 220	°C	
Processing (Melt) Temp	200 to 230	°C	
Mold Temperature	40.0 to 80.0	°C	
Back Pressure	0.490 to 0.981	MPa	
Screw Speed	50 to 100	rpm	
NOTE			
1.	1.0 mm/min		
2.	50 mm/min		
3.	50 mm/min		
4.	15 mm/min		
5.	15 mm/min		
6.	Rate A (50°C/h), Loading 2 (50 N)		

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