

LG ASA LI968W

Acrylonitrile Styrene Acrylate

LG Chem Ltd.

Message:

Description
Good Weatherability
Application
Window Profile, Siding, Rain Gutter

General Information			
Features	Good weather resistance		
Uses	Outdoor application		
Processing Method	Co-extrusion molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	11	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)	102		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	2060	MPa	ASTM D638
Tensile Strength ² (Yield, 3.20 mm)	47.1	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield, 3.20mm	> 6.0	%	ASTM D638
Fracture, 3.20mm	25	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	2260	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 3.20 mm)	73.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	39	J/m	ASTM D256
-30°C, 6.40 mm	39	J/m	ASTM D256
23°C, 3.20 mm	180	J/m	ASTM D256
23°C, 6.40 mm	140	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	95.0	°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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