

Generic ASA+PC

Acrylonitrile Styrene Acrylate + PC

Generic

Message:

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General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.10 - 1.25	g/cm ³	ASTM D792
23°C	1.11 - 1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
260°C/5.0 kg	14 - 45	g/10 min	ASTM D1238
260°C/5.0 kg	19 - 40	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	17.0 - 26.0	cm ³ /10min	ISO 1133
Molding Shrinkage			
Flow: 23°C	0.50 - 0.60	%	ASTM D955
23°C	0.59 - 0.70	%	ISO 294-4
Water Absorption			
23°C, 24 hr	0.10 - 0.25	%	ASTM D570
Saturated, 23°C	0.60 - 1.0	%	ISO 62
Equilibrium, 23°C, 50% RH	0.20 - 0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (23°C)	109 - 116		ASTM D785
Ball Indentation Hardness	88.7 - 110	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	2540 - 2720	MPa	ASTM D638
23°C	2120 - 2760	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	52.9 - 65.6	MPa	ASTM D638
Yield, 23°C	54.6 - 62.4	MPa	ISO 527-2
Fracture, 23°C	44.0 - 66.0	MPa	ASTM D638
Fracture, 23°C	39.0 - 64.3	MPa	ISO 527-2
Tensile Elongation			
Yield, 23°C	3.7 - 6.1	%	ASTM D638
Yield, 23°C	2.3 - 8.7	%	ISO 527-2
Fracture, 23°C	23 - 100	%	ASTM D638
Fracture, 23°C	36 - 80	%	ISO 527-2

Flexural Modulus			
23°C	2080 - 2770	MPa	ASTM D790
23°C	2000 - 2640	MPa	ISO 178
Flexural Strength			
23°C	68.0 - 94.0	MPa	ASTM D790
23°C	72.8 - 97.5	MPa	ISO 178
Yield, 23°C	81.7 - 95.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0 - 62	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	140 - 600	J/m	ASTM D256
23°C	16 - 61	kJ/m ²	ISO 180
Instrumented Dart Impact (23°C)	35.3 - 47.9	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	102 - 130	°C	ASTM D648
0.45 MPa, not annealed	98.4 - 132	°C	ISO 75-2/B
1.8 MPa, not annealed	87.7 - 113	°C	ASTM D648
1.8 MPa, not annealed	87.2 - 122	°C	ISO 75-2/A
Vicat Softening Temperature			
--	104 - 138	°C	ASTM D1525
--	102 - 139	°C	ISO 306
Linear thermal expansion coefficient			
Flow	7.2E-5 - 7.3E-5	cm/cm/°C	ASTM E831
Flow	1.0E-5 - 8.6E-5	cm/cm/°C	ISO 11359-2
Lateral	7.2E-5 - 7.9E-5	cm/cm/°C	ASTM E831
Lateral	7.1E-5 - 7.8E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13 - 1.0E+15	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+13 - 1.0E+15	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Glow Wire Ignition Temperature	550 - 960	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	78.8 - 120	°C	
Drying Time	3.0 - 3.6	hr	
Suggested Max Moisture	0.020 - 0.052	%	
Suggested Shot Size	55 - 60	%	
Rear Temperature	215 - 247	°C	
Middle Temperature	240 - 252	°C	
Front Temperature	250 - 260	°C	
Nozzle Temperature	240 - 255	°C	
Processing (Melt) Temp	249 - 281	°C	

Mold Temperature	60.0 - 80.7	°C
Back Pressure	0.300 - 0.785	MPa
Screw Speed	50 - 55	rpm
Vent Depth	0.057	mm

Injection instructions

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