

Infino WX-7010

Acrylonitrile Styrene Acrylate + PC

LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Infino WX-7010 is an acrylonitrile-styrene-acrylate PC (ASA PC) product. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. Typical application areas are: automotive industry. The main characteristics are: good weather resistance.

General Information			
Features	Good weather resistance		
Uses	Application in Automobile Field		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.16	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	30	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow: 3.20mm	0.40 - 0.70	%	ASTM D955
Transverse flow: 3.20mm	0.40 - 0.70	%	ASTM D955
Lateral flow: 3.20mm	0.40 - 0.70	%	ISO 2577
Traffic: 3.20mm	0.40 - 0.70	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	111		ASTM D785
R scale	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1900	MPa	ASTM D638
--	1950	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	54.0	MPa	ASTM D638
Yield	56.0	MPa	ISO 527-2/50
Fracture ³	49.0	MPa	ASTM D638
Fracture	50.0	MPa	ISO 527-2/50
Tensile Elongation			
Fracture ⁴	65	%	ASTM D638
Fracture	66	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2100	MPa	ASTM D790
-- ⁶	2250	MPa	ISO 178
Flexural Strength			
-- ⁷	74.0	MPa	ASTM D790
-- ⁸	80.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	60	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C, 3.18 mm	200	J/m	ASTM D256
-30°C, 6.35 mm	150	J/m	ASTM D256
23°C, 3.18 mm	640	J/m	ASTM D256
23°C, 6.35 mm	440	J/m	ASTM D256
-30°C ¹⁰	19	kJ/m ²	ISO 180/1A
23°C ¹¹	50	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 6.40mm	124	°C	ASTM D648
0.45 MPa, unannealed, 4.00mm	120	°C	ISO 75-2/B
1.8 MPa, unannealed, 6.40mm	108	°C	ASTM D648
1.8 MPa, not annealed, 4.00mm	101	°C	ISO 75-2/A
Vicat Softening Temperature	120	°C	ISO 306/B50
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: 40 to 100°C	8.0E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Horizontal: 40 to 100°C	8.5E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature			
--	90 - 110	°C	
Hot air dryer	80 - 100	°C	
Drying Time			
--	2.0 - 4.0	hr	
Hot air dryer	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	210 - 230	°C	
Middle Temperature	230 - 250	°C	
Front Temperature	250 - 265	°C	
Nozzle Temperature	280	°C	
Mold Temperature	60 - 90	°C	
Injection Pressure	78.5	MPa	
Back Pressure	0.490 - 2.45	MPa	
Screw Speed	50 - 80	rpm	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	50 mm/min		
4.	50 mm/min		
5.	2.8 mm/min		
6.	2.0 mm/min		

7.	2.8 mm/min
8.	2.0 mm/min
9.	Thickness: 4mm
10.	Thickness: 4mm
11.	Thickness: 4mm

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