

# LG ASA LI980-H

Acrylonitrile Styrene Acrylate

LG Chem Ltd.

## Message:

Description  
Good Weatherability, High gloss, High Flow  
Application  
Window Profile, Siding, Rain Gutter, Hand rail

| General Information                                              |                         |                   |             |
|------------------------------------------------------------------|-------------------------|-------------------|-------------|
| Features                                                         | Highlight               |                   |             |
|                                                                  | High liquidity          |                   |             |
|                                                                  | Good weather resistance |                   |             |
| Uses                                                             | Siding Applications     |                   |             |
|                                                                  | Doors and Windows       |                   |             |
|                                                                  | Profile                 |                   |             |
| Processing Method                                                | Co-extrusion molding    |                   |             |
| Physical                                                         | Nominal Value           | Unit              | Test Method |
| Specific Gravity                                                 | 1.09                    | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)                        | 30                      | 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)                                      | 110                     |                   | ASTM D785   |
| Mechanical                                                       | Nominal Value           | Unit              | Test Method |
| Tensile Strength <sup>1</sup> (Yield, 3.20 mm)                   | 49.0                    | MPa               | ASTM D638   |
| Tensile Elongation <sup>2</sup>                                  |                         |                   | ASTM D638   |
| Yield, 3.20mm                                                    | > 6.0                   | %                 | ASTM D638   |
| Fracture, 3.20mm                                                 | 45                      | %                 | ASTM D638   |
| Flexural Modulus <sup>3</sup> (3.20 mm)                          | 2160                    | MPa               | ASTM D790   |
| Flexural Strength <sup>4</sup> (3.20 mm)                         | 80.4                    | MPa               | ASTM D790   |
| Impact                                                           | Nominal Value           | Unit              | Test Method |
| Notched Izod Impact (23°C, 6.40 mm)                              | 78                      | J/m               | ASTM D256   |
| Thermal                                                          | Nominal Value           | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm) | 85.0                    | °C                | ASTM D648   |
| Flammability                                                     | Nominal Value           |                   | Test Method |
| Flame Rating                                                     |                         |                   | UL 94       |
| 1.6 mm                                                           | HB                      |                   | UL 94       |
| 3.2 mm                                                           | HB                      |                   | UL 94       |

| Extrusion             | Nominal Value | Unit |
|-----------------------|---------------|------|
| Drying Temperature    | 80 - 90       | °C   |
| Drying Time           | 2.0 - 3.0     | hr   |
| 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

Minimum Moisture Content: 0.01%Roll Stack Temperature, Top: 70 to 90°CRoll Stack Temperature, Middle: 70 to 90°CRoll Stack Temperature, Bottom: 70 to 100°C

#### NOTE

1. 50 mm/min
2. 50 mm/min
3. 15 mm/min
4. 15 mm/min

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