

LG ASA LI918

Acrylonitrile Styrene Acrylate

LG Chem Ltd.

Message:

Description

Good Weatherability, Good Colorability, High Flow

Application

Mail Box, Sprinkler, Sash Joiner, Toy, Satellite Antenna Cover, Air-conditioner grill, Electric/Electronic Applications.

General Information			
UL YellowCard	E67171-102424434		
Features	Good coloring		
	High liquidity		
	Good weather resistance		
Uses	Electrical/Electronic Applications		
	Home appliance components		
	Outdoor application		
	Toys		
Processing Method	Injection molding		
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 (3.20 mm)	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	104		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	48.1	MPa	ASTM D638
Tensile Elongation ²			ASTM D638
Yield, 3.20mm	> 6.0	%	ASTM D638
Fracture, 3.20mm	25	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2210	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	76.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	170	J/m	ASTM D256
23°C, 6.40 mm	160	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	86.0	°C	ASTM D648

Vicat Softening Temperature	95.0	°C	ASTM D1525 ⁵
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.6 mm	HB		UL 94
3.2 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80 - 90	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	180 - 200	°C	
Middle Temperature	190 - 210	°C	
Front Temperature	210 - 220	°C	
Nozzle Temperature	210 - 220	°C	
Processing (Melt) Temp	200 - 230	°C	
Mold Temperature	40 - 80	°C	
Back Pressure	0.490 - 0.981	MPa	
Screw Speed	50 - 100	rpm	
Injection instructions			
Minimum Moisture Content: 0.01%			
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	15 mm/min		
4.	15 mm/min		
5.	速率 A (50°C/h), 载荷2 (50N)		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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