

Starex WR-9160

Acrylonitrile Styrene Acrylate
SAMSUNG SDI CO., LTD.

Message:
ASA material that is applied to electric goods etc.

General Information			
UL YellowCard	E115797-100038692		
Uses	Electrical/Electronic Applications		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	94		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	40.0	MPa	ASTM D638
Tensile Elongation ² (Break)	120	%	ASTM D638
Flexural Modulus ³	1800	MPa	ASTM D790
Flexural Strength ⁴	60.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	410	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	82.0	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	HB		
3.00 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature			
--	80.0 to 90.0	°C	
Desiccant Dryer	80.0	°C	
Drying Time			
--	2.0 to 4.0	hr	
Desiccant Dryer	2.0 to 3.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	180 to 190	°C	
Middle Temperature	200 to 210	°C	
Front Temperature	220 to 230	°C	

Nozzle Temperature	240	°C
Mold Temperature	40.0 to 80.0	°C
Injection Pressure	49.0 to 245	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	50 to 150	rpm

NOTE

1.	5.0 mm/min
2.	5.0 mm/min
3.	2.8 mm/min
4.	2.8 mm/min

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