

KumhoSunny ASA XC811

Acrylonitrile Styrene Acrylate
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
ASAXC811 is a type of high heat-resistance grade of ASA resin, with excellent weatherability, high rigidity and toughness. Application:automotive exteriors like radiator grille, pillar board, rearview mirror, licence plate borad, etc.

General Information			
Features	Good Toughness		
	Good Weather Resistance		
	High Heat Resistance		
	High Rigidity		
Uses	Automotive Applications		
	Automotive Exterior Parts		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.08	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.0	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 to 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	50.0	MPa	ISO 527-2/50
Tensile Strain (Break)	20	%	ISO 527-2/50
Flexural Modulus ¹	2200	MPa	ISO 178
Flexural Stress ²	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	8.0	kJ/m ²	
23°C	16	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)			ISO 179
80		kJ/m ²	
Notched Izod Impact Strength ⁵ (23°C)			ISO 180
15		kJ/m ²	
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed)	95.0	°C	ISO 75-2/A
Vicat Softening Temperature	105	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 95.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	200 to 220	°C	
Middle Temperature	230 to 240	°C	
Front Temperature	245 to 260	°C	
Nozzle Temperature	240 to 250	°C	
Processing (Melt) Temp	240 to 260	°C	
Mold Temperature	50.0 to 80.0	°C	
Back Pressure	1.00 to 5.00	MPa	
Screw Speed	30 to 70	rpm	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	Condition: 4 J		
4.	Condition: 4 J		
5.	Condition: 5.5 J		
6.	120°C/h		

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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

