

Infino WR-7390

Acrylonitrile Styrene Acrylate + PC
LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Infino WR-7390 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.
Features include:
good weather resistance
Heat resistance

General Information			
Features	Good Heat Resistance		
	Good weather resistance		
Uses	Application in Automobile Field		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.17	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	32	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow: 3.20mm	0.50 - 0.90	%	ASTM D955
Traffic: 3.20mm	0.50 - 0.90	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	118		ASTM D785
R scale	116		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2100	MPa	ASTM D638
--	2120	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	54.0	MPa	ASTM D638
Yield	58.0	MPa	ISO 527-2/50
Fracture ³	65.0	MPa	ASTM D638
Fracture	61.0	MPa	ISO 527-2/50
Tensile Elongation			
Fracture ⁴	110	%	ASTM D638
Fracture	90	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2400	MPa	ASTM D790
-- ⁶	2140	MPa	ISO 178
Flexural Strength			

-- 7	78.0	MPa	ASTM D790
-- 8	84.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	56	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	650	J/m	ASTM D256
23°C ¹⁰	40	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, unannealed, 4.00mm	127	°C	ISO 75-2/B
1.8 MPa, unannealed, 6.40mm	112	°C	ASTM D648
1.8 MPa, not annealed, 4.00mm	111	°C	ISO 75-2/A
	130		
Vicat Softening Temperature	134	°C	ISO 306/B50
Injection	Nominal Value	Unit	
Drying Temperature			
--	120	°C	
Hot air dryer	120	°C	
Drying Time			
--	4.0	hr	
Hot air dryer	4.0	hr	
Suggested Max Moisture	0.050 - 0.070	%	
Rear Temperature	270	°C	
Middle Temperature	270	°C	
Front Temperature	280	°C	
Nozzle Temperature	290	°C	
Mold Temperature	60	°C	
Injection Pressure	93.0	MPa	
Back Pressure	0.500	MPa	
Screw Speed	50	rpm	
Injection instructions			
Hot Runner Manifold Temperature: 280°C Hot Runner Valve Nozzle Temperature: 280°C			
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

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