

# SAXATEC™ 4115

Acrylonitrile Styrene Acrylate

SAX Polymers

Message:

SAXATEC 4115 is a medium viscosity, weatherable ASA injection molding grade, characterized by high impact strength, high stiffness and good resistance to heat distortion.

| General Information                         |                         |                        |                 |
|---------------------------------------------|-------------------------|------------------------|-----------------|
| Features                                    | Good Weather Resistance |                        |                 |
|                                             | High Heat Resistance    |                        |                 |
|                                             | High Impact Resistance  |                        |                 |
|                                             | High Stiffness          |                        |                 |
|                                             | Medium Viscosity        |                        |                 |
| RoHS Compliance                             | RoHS Compliant          |                        |                 |
| Processing Method                           | Injection Molding       |                        |                 |
| Physical                                    | Nominal Value           | Unit                   | Test Method     |
| Density                                     | 1.07                    | g/cm <sup>3</sup>      | ISO 1183        |
| Melt Volume-Flow Rate (MVR) (220°C/10.0 kg) | 15.0                    | cm <sup>3</sup> /10min | ISO 1133        |
| Molding Shrinkage                           | 0.40 to 0.70            | %                      | ISO 294-4       |
| Moisture Content <sup>1</sup>               | < 0.20                  | %                      | Internal Method |
| Mechanical                                  | Nominal Value           | Unit                   | Test Method     |
| Tensile Modulus (23°C)                      | 2800                    | MPa                    | ISO 527-2       |
| Tensile Stress (Break, 23°C)                | 62.0                    | MPa                    | ISO 527-2       |
| Tensile Strain (Break, 23°C)                | 10                      | %                      | ISO 527-2       |
| Impact                                      | Nominal Value           | Unit                   | Test Method     |
| Charpy Notched Impact Strength              |                         |                        | ISO 179/1eA     |
| -30°C                                       | 5.0                     | kJ/m <sup>2</sup>      |                 |
| 23°C                                        | 7.0                     | kJ/m <sup>2</sup>      |                 |
| Charpy Unnotched Impact Strength            |                         |                        | ISO 179/1eU     |
| -30°C                                       | 60                      | kJ/m <sup>2</sup>      |                 |
| 23°C                                        | 100                     | kJ/m <sup>2</sup>      |                 |
| Notched Izod Impact Strength                |                         |                        | ISO 180/1A      |
| -30°C                                       | 5.0                     | kJ/m <sup>2</sup>      |                 |
| 23°C                                        | 7.0                     | kJ/m <sup>2</sup>      |                 |
| Unnotched Izod Impact Strength              |                         |                        | ISO 180         |
| -30°C                                       | 40                      | kJ/m <sup>2</sup>      |                 |
| 23°C                                        | 80                      | kJ/m <sup>2</sup>      |                 |
| Thermal                                     | Nominal Value           | Unit                   | Test Method     |

| Heat Deflection Temperature <sup>2</sup> (1.8 MPa, Unannealed, 60.0 mm Span) | 89.0          | °C   | ISO 75-2/A     |
|------------------------------------------------------------------------------|---------------|------|----------------|
| Vicat Softening Temperature                                                  | 104           | °C   | ISO 306/B50    |
| Ball Pressure Test (95°C, 2.00 mm)                                           | Pass          |      | IEC 60335-1    |
| Flammability                                                                 | Nominal Value | Unit | Test Method    |
| Glow Wire Flammability Index                                                 | 750           | °C   | IEC 60695-2-12 |
| Injection                                                                    | Nominal Value | Unit |                |
| Drying Temperature                                                           | 80.0          | °C   |                |
| Drying Time                                                                  | 2.0 to 4.0    | hr   |                |
| Processing (Melt) Temp                                                       | 220 to 260    | °C   |                |
| Mold Temperature                                                             | 60.0 to 90.0  | °C   |                |
| NOTE                                                                         |               |      |                |
| 1.                                                                           | B130          |      |                |
| 2.                                                                           | 80*10*4mm     |      |                |

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