

# KumhoSunny ASA XC811-HW

Acrylonitrile Styrene Acrylate  
Shanghai KumhoSunny Plastics Co., Ltd.

Message:  
ASAXC811 is a type of high heat-resistance grade of ASA resin, with better weatherability than ASA XC811, 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)                                                 | 1.09                      | g/cm <sup>3</sup> | 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                                                 | 55.0                      | MPa               | ISO 527-2/50 |
| Tensile Strain (Break)                                         | 15                        | %                 | ISO 527-2/50 |
| Flexural Modulus <sup>1</sup>                                  | 2400                      | MPa               | ISO 178      |
| Flexural Stress <sup>2</sup>                                   | 75.0                      | MPa               | ISO 178      |
| Impact                                                         | Nominal Value             | Unit              | Test Method  |
| Charpy Notched Impact Strength <sup>3</sup> (23°C)             | 13                        | kJ/m <sup>2</sup> | ISO 179      |
| Charpy Unnotched Impact Strength <sup>4</sup> (23°C)           | No Break                  |                   | ISO 179      |
| Thermal                                                        | Nominal Value             | Unit              | Test Method  |
| Heat Deflection Temperature <sup>5</sup> (1.8 MPa, Unannealed) | 92.0                      | °C                | ISO 75-2/A   |
| Vicat Softening Temperature                                    | 102                       | °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.                     | 120°C/h        |         |             |

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