

UMG ALLOY® FA-840CD

Acrylonitrile Styrene Acrylate + PC

UMG ABS, Ltd.

Message:

UMG ALLOY® FA-840CD is an Acrylonitrile Styrene Acrylate + PC (ASA+PC) material. It is available in Asia Pacific or North America for injection molding. Important attributes of UMG ALLOY® FA-840CD are:

Flame Rated

RoHS Compliant

General Information			
RoHS Compliance	RoHS Compliant		
UL File Number	E47016		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.27	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	16.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (23°C)	0.10 to 0.20	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	122		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	14600	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	140	MPa	ISO 527-2
Flexural Modulus ¹ (23°C)	14800	MPa	ISO 178
Flexural Stress ² (23°C)	180	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	98.0	°C	ISO 75-2/Af
CLTE - Flow	1.0E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating (1.00 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 105	°C	
Drying Time	3.0 to 4.0	hr	
Rear Temperature	220 to 240	°C	
Middle Temperature	240 to 260	°C	
Front Temperature	250 to 270	°C	
Nozzle Temperature	240 to 260	°C	
Processing (Melt) Temp	250 to 270	°C	

Mold Temperature	60.0 to 80.0	°C
Injection Pressure	70.0 to 140	MPa
Injection Rate	Fast	
Back Pressure	5.00 to 15.0	MPa
Screw Speed	40 to 60	rpm

NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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