

LG ASA LI912

Acrylonitrile Styrene Acrylate

LG Chem Ltd.

Message:

Description
Good Weatherability, General Purpose
Application
Mail Box, Sprinkler, Sash Joiner, Toy, Satellite Antenna Cover

General Information			
UL YellowCard	E67171-248322		
Features	Good weather resistance		
	General		
Uses	Outdoor application		
	Toys		
Forms	Particle		
Processing Method	Injection molding		
Multi-Point Data	Specific Heat vs. Temperature (ISO 11403-2)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	103		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	2080	MPa	ASTM D638
Tensile Strength ² (Yield, 3.20 mm)	47.1	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield, 3.20mm	> 6.0	%	ASTM D638
Fracture, 3.20mm	25	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	2210	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	75.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	39	J/m	ASTM D256
-30°C, 6.40 mm	39	J/m	ASTM D256
23°C, 3.20 mm	180	J/m	ASTM D256
23°C, 6.40 mm	160	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	96.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	86.0	°C	ASTM D648
Vicat Softening Temperature	95.0	°C	ASTM D1525 ⁶
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	180 - 200	°C	
Middle Temperature	190 - 210	°C	
Front Temperature	210 - 220	°C	
Nozzle Temperature	210 - 220	°C	
Processing (Melt) Temp	200 - 230	°C	
Mold Temperature	40.0 - 80.0	°C	
Back Pressure	0.490 - 0.981	MPa	
Screw Speed	50 - 100	rpm	
Injection instructions			
Minimum Moisture Content: 0.01%			
NOTE			
1.	1.0 mm/min		
2.	50 mm/min		
3.	50 mm/min		
4.	15 mm/min		
5.	15 mm/min		
6.	速率 A (50°C/h), 载荷2 (50N)		

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