

LG ASA LI931-C

Acrylonitrile Styrene Acrylate

LG Chem Ltd.

Message:

Description
Low Gloss, Good Weatherability
Application
Industrial Materials (Window Profile, Tile Etc)

General Information			
Features	Gloss, low		
	Good weather resistance		
Uses	Industrial application		
	Profile		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	6.0	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)	80		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	29.4	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	30	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1320	MPa	ASTM D790
Flexural Strength ⁴ (6.40 mm)	41.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	78.0	°C	ASTM D648
Optical	Nominal Value		Test Method
Gloss (45°)	30		ASTM D2457
Extrusion	Nominal Value	Unit	
Drying Temperature	70 - 80	°C	
Drying Time	3.0 - 4.0	hr	
Cylinder Zone 1 Temp.	180 - 210	°C	
Cylinder Zone 2 Temp.	190 - 230	°C	
Cylinder Zone 3 Temp.	200 - 250	°C	

Cylinder Zone 4 Temp.	200 - 250	°C
Adapter Temperature	200 - 250	°C
Melt Temperature	200 - 250	°C
Die Temperature	200 - 250	°C

Extrusion instructions

Minimum Moisture Content: 0.01%Roll Stack Temperature, Top: 70 to 100°CRoll Stack Temperature, Middle: 70 to 90°CRoll Stack Temperature, Bottom: 60 to 90°C

NOTE

1.	50 mm/min
2.	50 mm/min
3.	15 mm/min
4.	15 mm/min

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