

Centrex® 810

Acrylonitrile Styrene Acrylate

Network Polymers, Inc.

Message:

Centrex® 810 is an Acrylonitrile Styrene Acrylate (ASA) product. It can be processed by injection molding and is available in North America. Typical application: Outdoor Applications.

Characteristics include:

REACH Compliant

RoHS Compliant

WEEE Compliant

Good Processability

Good Weather Resistance

General Information			
Features	Good Processability		
	Good Weather Resistance		
	High Flow		
	High Gloss		
	Medium Impact Resistance		
Uses	Outdoor Applications		
Agency Ratings	EC 1907/2006 (REACH)		
	EU 2002/96/EC (WEEE)		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	21	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2460	MPa	ASTM D638
Tensile Strength ² (Yield)	40.7	MPa	ASTM D638
Flexural Modulus - Tangent ³	2390	MPa	ASTM D790
Flexural Strength ⁴	70.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.18 mm	53	J/m	
0°C, 3.18 mm	64	J/m	

23°C, 3.18 mm	85	J/m	
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	10.0	J	
0°C, Total Energy	40.0	J	
23°C, Total Energy	45.0	J	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.18 mm	74.0	°C	
1.8 MPa, Unannealed, 6.35 mm	80.0	°C	
Vicat Softening Temperature			
--	93.0	°C	ASTM D1525 ⁵
--	104	°C	ASTM D1525 ⁶
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	82.2 to 87.8	°C	
Drying Time - Desiccant Dryer	2.0	hr	
Dew Point - Desiccant Dryer	-28.9	°C	
Suggested Max Moisture	0.10	%	
Suggested Shot Size	50 to 70	%	
Suggested Max Regrind	20	%	
Rear Temperature	238 to 271	°C	
Middle Temperature	238 to 271	°C	
Front Temperature	238 to 271	°C	
Nozzle Temperature	238 to 271	°C	
Processing (Melt) Temp	238 to 271	°C	
Mold Temperature	43.3 to 82.2	°C	
Injection Rate	Moderate		
Screw L/D Ratio	20.0:1.0		
Screw Compression Ratio	2.5:1.0		
NOTE			
1.	5.1 mm/min		
2.	5.1 mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	Rate A (50°C/h), Loading 2 (50 N)		
6.	Rate B (120°C/h), Loading 1 (10 N)		

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