

KumhoSunny ASA XC220

Acrylonitrile Styrene Acrylate
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
ASAXC811 is a type of general ASA resin, with excellent weatherability and high impact .

General Information			
Features	General Purpose		
	Good Weather Resistance		
	High Impact Resistance		
Uses	Electrical/Electronic Applications		
	General Purpose		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
220°C/10.0 kg	12	g/10 min	ASTM D1238
220°C/10.0 kg	10	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.40 to 0.70	%	ASTM D955
--	0.40 to 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	47.0	MPa	ASTM D638
--	48.0	MPa	ISO 527-2/50
Tensile Elongation			
Break	30	%	ASTM D638
Break	20	%	ISO 527-2/50
Flexural Modulus			
--	2100	MPa	ASTM D790
-- ¹	2300	MPa	ISO 178
Flexural Strength			

--	71.0	MPa	ASTM D790
-- ²	68.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	8.0	kJ/m ²	
23°C	18	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)	No Break		ISO 179
Notched Izod Impact			
3.20 mm	220	J/m	ASTM D256
23°C ⁵	17	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	85.0	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	95.0	°C	ISO 306/B50, ASTM D1525 ⁶
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+14	ohms	IEC 60093
Volume Resistivity	> 1.0E+14	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 85.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	200 to 220	°C	
Middle Temperature	210 to 230	°C	
Front Temperature	230 to 250	°C	
Nozzle Temperature	230 to 240	°C	
Processing (Melt) Temp	220 to 240	°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.	4J		
4.	4J		
5.	5.5J		
6.	Rate B (120°C/h)		

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