

Starex WR-9100

Acrylonitrile Styrene Acrylate
SAMSUNG SDI CO., LTD.

Message:

Starex WR-9100 is an Acrylonitrile Styrene Acrylate (ASA) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Primary characteristic: flame rated.

General Information			
UL YellowCard		E115797-548129	
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	22	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	102		ASTM D785
R-Scale	107		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield ¹	45.0	MPa	ASTM D638
Yield	45.0	MPa	ISO 527-2/50
Tensile Elongation ² (Break)	80	%	ASTM D638
Flexural Modulus			
-- ³	2000	MPa	ASTM D790
-- ⁴	2400	MPa	ISO 178
Flexural Strength			
-- ⁵	59.0	MPa	ASTM D790
-- ⁶	75.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁷ (23°C)	12	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	200	J/m	ASTM D256
23°C ⁸	9.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	85.0	°C	ASTM D648
Vicat Softening Temperature	97.0	°C	ISO 306/B50
Flammability	Nominal Value	Test Method	
Flame Rating		UL 94	
1.50 mm	HB		

3.00 mm	HB	
Injection	Nominal Value	Unit
Drying Temperature		
--	80.0 to 90.0	°C
Desiccant Dryer	80.0	°C
Drying Time		
--	2.0 to 4.0	hr
Desiccant Dryer	2.0 to 3.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	180 to 190	°C
Middle Temperature	200 to 210	°C
Front Temperature	220 to 230	°C
Nozzle Temperature	240	°C
Mold Temperature	40.0 to 80.0	°C
Injection Pressure	49.0 to 245	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	50 to 150	rpm

NOTE

- | | |
|----|-----------------|
| 1. | 5.0 mm/min |
| 2. | 5.0 mm/min |
| 3. | 2.8 mm/min |
| 4. | 2.0 mm/min |
| 5. | 2.8 mm/min |
| 6. | 2.0 mm/min |
| 7. | Thickness: 4 mm |
| 8. | Thickness: 4 mm |

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

