

DIALAC® S411A

Acrylonitrile Styrene Acrylate

UMG ABS, Ltd.

Message:

DIALAC® S411A is an Acrylonitrile Styrene Acrylate (ASA) material. It is available in Asia Pacific or North America for injection molding. Primary attribute of DIALAC® S411A: RoHS Compliant.

General Information			
RoHS Compliance	RoHS Compliant		
UL File Number	E47016		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.06	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	60.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (23°C)	0.40 to 0.60	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	108		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2200	MPa	ISO 527-2
Tensile Stress (23°C)	42.0	MPa	ISO 527-2
Flexural Modulus ¹ (23°C)	2400	MPa	ISO 178
Flexural Stress ² (23°C)	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	2.0	kJ/m ²	
23°C	9.0	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	78.0	°C	ISO 75-2/Af
CLTE - Flow	8.5E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	
Rear Temperature	190 to 210	°C	
Middle Temperature	210 to 230	°C	
Front Temperature	220 to 250	°C	
Nozzle Temperature	200 to 230	°C	
Processing (Melt) Temp	220 to 260	°C	
Mold Temperature	50.0 to 60.0	°C	

Injection Pressure	70.0 to 140	MPa
Injection Rate	Moderate	
Back Pressure	5.00 to 15.0	MPa
Screw Speed	50 to 100	rpm
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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Recommended distributors for this material

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