

KIBILAC® PW-978B

Acrylonitrile Styrene Acrylate

CHI MEI CORPORATION

Message:

KIBILAC® PW-978B is an Acrylonitrile Styrene Acrylate (ASA) product. It can be processed by injection molding and is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Primary characteristic: rohs compliant.

General Information			
UL YellowCard	E56070-561245		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	13	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	12.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	88.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			
Yield	49.0	MPa	ISO 527-2/50
Break	38.0	MPa	ISO 527-2/50
3.18 mm ¹	46.1	MPa	ASTM D638
Tensile Strain (Break)	20	%	ISO 527-2/50
Flexural Modulus ²	1900	MPa	ISO 178
Flexural Strength			
6.35 mm ³	66.7	MPa	ASTM D790
-- ⁴	67.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	12	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	No Break		ISO 179
Notched Izod Impact			
23°C, 3.18 mm	250	J/m	ASTM D256
23°C, 6.35 mm	110	J/m	ASTM D256
--	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 6.35 mm ⁵	93.0	°C	ASTM D648
1.8 MPa, Unannealed	94.0	°C	ISO 75-2/A

1.8 MPa, Annealed, 6.35 mm ⁶	103	°C	ASTM D648
1.8 MPa, Annealed	108	°C	ISO 75-2/A
Vicat Softening Temperature			
--	113	°C	ASTM D1525 ⁷
--	114	°C	ISO 306/A50
--	115	°C	ISO 306/A120
--	100	°C	ISO 306/B50
--	104	°C	ISO 306/B120
Optical	Nominal Value		Test Method
Gardner Gloss	97		ASTM D523
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 95.0	°C	
Drying Time	3.0	hr	
Rear Temperature	230 to 250	°C	
Middle Temperature	240 to 260	°C	
Front Temperature	240 to 260	°C	
Mold Temperature	40.0 to 80.0	°C	
Injection Pressure	4.90 to 6.86	MPa	
Holding Pressure	3.92 to 5.88	MPa	
Back Pressure	0.490 to 1.47	MPa	
NOTE			
1.	6.0 mm/min		
2.	2.0 mm/min		
3.	2.8 mm/min		
4.	2.0 mm/min		
5.	120°C/hr		
6.	120°C/hr		
7.	Rate A (50°C/h)		

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