

Diamond ASA T-120

Acrylonitrile Styrene Acrylate
Network Polymers, Inc.

Message:

Diamond ASA T-120 is an Acrylonitrile Styrene Acrylate (ASA) product. It can be processed by injection molding and is available in North America. Characteristics include:
REACH Compliant
RoHS Compliant
WEEE Compliant
Good Weather Resistance
Heat Resistant

General Information			
Features	Good Weather Resistance		
	High Heat Resistance		
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	1.07	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹			ASTM D1238
200°C/5.0 kg	0.70	g/10 min	
230°C/3.8 kg	2.8	g/10 min	
Molding Shrinkage - Flow	0.30 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	104		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	47.4	MPa	ASTM D638
Flexural Modulus - Tangent ³	2390	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	91	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.18 mm	92.2	°C	
1.8 MPa, Unannealed, 6.35 mm	100	°C	
Vicat Softening Temperature	123	°C	ASTM D1525 ⁴
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	

Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Suggested Shot Size	40 to 70	%
Suggested Max Regrind	30	%
Rear Temperature	230 to 260	°C
Middle Temperature	232 to 265	°C
Front Temperature	235 to 272	°C
Nozzle Temperature	220 to 272	°C
Processing (Melt) Temp	220 to 272	°C
Mold Temperature	40.0 to 80.0	°C
Injection Rate	Fast	
Back Pressure	0.517 to 1.03	MPa

NOTE

1. Procedure A
2. 51 mm/min
3. 1.3 mm/min
4. Loading 1 (10 N)

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