

Diamond ASA C1030

Acrylonitrile Styrene Acrylate

Network Polymers, Inc.

Message:

Diamond ASA C1030 is an Acrylonitrile Styrene Acrylate (ASA) product. It can be processed by extrusion or injection molding and is available in North America.

Characteristics include:

REACH Compliant

RoHS Compliant

WEEE Compliant

Good Weather Resistance

General Information			
Features	Good Colorability		
	Good Weather Resistance		
Agency Ratings	EC 1907/2006 (REACH)		
	EU 2002/96/EC (WEEE)		
RoHS Compliance	RoHS Compliant		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (220°C/10.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	45.9	MPa	ASTM D638
Tensile Elongation ³ (Break)	30	%	ASTM D638
Flexural Modulus - Tangent ⁴ (3.18 mm, 50.8 mm Span)	1970	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	130	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm, Injection Molded	81.1	°C	ASTM D1525 ⁵
1.8 MPa, Unannealed, 3.18 mm	67.8	°C	
Vicat Softening Temperature	95.0	°C	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	

Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 70	%
Suggested Max Regrind	25	%
Rear Temperature	230 to 260	°C
Middle Temperature	232 to 260	°C
Front Temperature	235 to 260	°C
Nozzle Temperature	220 to 260	°C
Processing (Melt) Temp	220 to 260	°C
Mold Temperature	71.1 to 82.2	°C
Injection Rate	Fast	
Back Pressure	0.517 to 1.03	MPa

NOTE

1. Procedure A
2. Type I, 51 mm/min
3. Type I, 51 mm/min
4. Method I (3 point load), 1.3 mm/min
5. Rate B (120°C/h), Loading 1 (10 N)

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