

Diamond ASA S246

Acrylonitrile Styrene Acrylate
Network Polymers, Inc.

Message:

Diamond ASA S246 is an Acrylonitrile Styrene Acrylate (ASA) product. It can be processed by injection molding and is available in North America. Characteristics include:
RoHS Compliant
WEEE Compliant
Good Flexibility
Good Weather Resistance

General Information			
Features	Good Flexibility		
	Good Weather Resistance		
Agency Ratings	EU 2002/96/EC (WEEE)		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (220°C/10.0 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus - Tangent ² (23°C, Injection Molded)	2570	MPa	ASTM D638
Tensile Strength ³ (Yield, 23°C, Injection Molded)	45.9	MPa	ASTM D638
Tensile Elongation ⁴ (Yield, 23°C, Injection Molded)	2.9	%	ASTM D638
Flexural Modulus - Tangent ⁵ (3.18 mm, 50.8 mm Span)	2500	MPa	ASTM D790
Flexural Strength ⁶ (Yield, 23°C, 3.18 mm, Injection Molded, 50.8 mm Span)	75.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm, Injection Molded)	78.9	°C	ASTM D648
Vicat Softening Temperature	106	°C	ASTM D1525 ⁷
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	2.0 to 4.0	hr	

Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 70	%
Suggested Max Regrind	25	%
Rear Temperature	230 to 249	°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	65.6 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. Type I, 51 mm/min
5. Method I (3 point load), 1.3 mm/min
6. Method I (3 point load), 1.3 mm/min
7. Rate B (120°C/h), Loading 1 (10 N)

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