

General Information
Product Description

Description

- Good Weatherability, Scratch Resistance, High Flow

Application

- Window Profile, Siding, Rain Gutter

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific • Europe	• Latin America • North America	
Features	• Good Scratch Resistance	• High Flow	• Weather Resistant
Uses	• Profiles	• Siding Applications	• Windows & Doors
Processing Method	• Coextrusion		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ² (3.20 mm)	2200	MPa	ASTM D638
Tensile Strength ³ (Yield, 3.20 mm)	50.0	MPa	ASTM D638
Tensile Elongation ³ (Yield, 3.20 mm)	> 6.0	%	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	20	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	2260	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	76.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	20	J/m	
-30°C, 6.40 mm	20	J/m	
23°C, 3.20 mm	59	J/m	
23°C, 6.40 mm	59	J/m	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed, 6.40 mm	95.0	°C	ASTM D648
Deflection Temperature Under Load 1.8 MPa, Unannealed, 6.40 mm	85.0	°C	ASTM D648
Vicat Softening Temperature	90.0	°C	ASTM D1525 ⁵

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LG ASA LI970HF

LG Chem Ltd. - Acrylonitrile Styrene Acrylate

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	80 to 90	°C
Drying Time	2.0 to 3.0	hr
Cylinder Zone 1 Temp.	190 to 200	°C
Cylinder Zone 2 Temp.	200 to 220	°C
Cylinder Zone 3 Temp.	210 to 230	°C
Cylinder Zone 4 Temp.	210 to 230	°C
Adapter Temperature	210 to 230	°C
Melt Temperature	200 to 230	°C
Die Temperature	210 to 250	°C

Extrusion Notes

Minimum Moisture Content: 0.01%

Roll Stack Temperature, Top: 70 to 90°C

Roll Stack Temperature, Middle: 70 to 90°C

Roll Stack Temperature, Bottom: 70 to 100°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 1.0 mm/min

³ 50 mm/min

⁴ 15 mm/min

⁵ Rate A (50°C/h), Loading 2 (50 N)