

LG ASA LI911

LG Chem Ltd. - Acrylonitrile Styrene Acrylate

Friday, May 24, 2019

General Information

Product Description

Description

- Good Weatherability, High Flow

Applications

- Air-conditioner grill, Sewing Machine Cover, Electric/Electronic Applications

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific • Europe	• Latin America • North America	
Features	• High Flow	• Weather Resistant	
Uses	• Appliance Components	• Electrical/Electronic Applications	
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.07	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	20	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)	2170	MPa	ASTM D638
Tensile Strength ³ (Yield, 3.20 mm)	49.0	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)	2300	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	78.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	29	J/m	
-30°C, 6.40 mm	29	J/m	
23°C, 3.20 mm	140	J/m	
23°C, 6.40 mm	120	J/m	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	107		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed, 6.40 mm	96.0	°C	ASTM D648
Deflection Temperature Under Load 1.8 MPa, Unannealed, 6.40 mm	87.0	°C	ASTM D648
Vicat Softening Temperature	96.0	°C	ASTM D1525 ⁵

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Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.6 mm		HB	
3.2 mm		HB	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	80 to 90	°C
Drying Time	2.0 to 3.0	hr
Rear Temperature	180 to 200	°C
Middle Temperature	190 to 210	°C
Front Temperature	210 to 220	°C
Nozzle Temperature	210 to 220	°C
Processing (Melt) Temp	200 to 230	°C
Mold Temperature	40 to 80	°C
Back Pressure	0.490 to 0.981	MPa
Screw Speed	50 to 100	rpm

Injection Notes

Minimum Moisture Content: 0.01%

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)