

ASA LI913

Extrusion Molding

Description

Good Weatherability, High Impact

Application

Satellite Antenna, Boat, Lamp Cover, Door Frame,
Electronic Components

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.07
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.7
Melt Flow Rate	220°C/10kg	ASTM D1238	g/10min	5
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	410
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	>5
@ Break	50mm/min		%	35
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	17,600
Flexural Strength, 3.2mm	15mm/min	ASTM D790	kg/cm ²	630
Flexural Modulus, 3.2mm	15mm/min	ASTM D790	kg/cm ²	18,500
IZOD Impact Strength, 6.4mm (Notched)		ASTM D256		
	23°C		kg·cm/cm	35
	-30°C		kg·cm/cm	6
IZOD Impact Strength, 3.2mm (Notched)		ASTM D256		
	23°C		kg·cm/cm	45
	-30°C		kg·cm/cm	6
Rockwell Hardness	R-Scale	ASTM D785	-	92
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)		ASTM D648		
	18.6kg		°C	86
	4.6kg		°C	96
Vicat Softening Temperature		ASTM D1525		
	5kg, 50°C/h		°C	94
Flammability		UL94		
0.8mm			class	
1.6mm			class	HB
2.5mm			class	
3.2mm			class	HB
Relative Temperature Index		UL 746B		
Electrical			°C	
Mechanical with Impact			°C	
Mechanical without Impact			°C	

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection molded specimens and after 48 hours storage at 23°C, 50% relative humidity.

Updated : 29-Jul-14

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Processing Guide (Extrusion Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	80 ~ 90
Drying Time		hrs	2 ~ 3
Minimum Moisture Content		%	0.01
Melt Temperature		℃	200 ~ 230
Barrel Temperature	Zone 1	℃	190 ~ 200
	Zone 2	℃	200 ~ 220
	Zone 3	℃	210 ~ 230
	Zone 4	℃	210 ~ 230
Adapter Temperature		℃	210 ~ 230
Die Temperature		℃	210 ~ 250
Roll Stack Temperature	Top	℃	70 ~ 90
	Middle	℃	70 ~ 90
	Bottom	℃	70 ~ 100

Note) Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.

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