

LG ASA LI-913

Acrylonitrile Styrene Acrylate

LG Chem Ltd.

General		
Material Status	• Commercial: Active	
Availability	• Asia Pacific • Europe	• North America • South America
Forms	• Pellets	
Processing Method	• Extrusion	• Injection Molding
Multi-Point Data	• Specific Heat vs. Temperature (ISO 11403-2)	

Physical	Nominal Value	Unit	Test Method
Specific Gravity	--	1.07 g/cm ³	ASTM D792
	--	1070 kg/m ³	ISO 1183 ²
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)		6.0 g/10 min	ASTM D1238
Melt volume-flow rate (220°C/10.0 kg)		7.80 cm ³ /10min	ISO 1133 ²
Molding Shrinkage - Flow		0.40 to 0.70 %	ASTM D955
Water Absorption (Saturation)		0.40 %	ISO 62 ²

Mechanical	Nominal Value	Unit	Test Method
Tensile modulus		1100 MPa	ISO 527-2 ²
Tensile Strength			
Yield		39.3 MPa	ASTM D638
Yield		39.0 MPa	ISO 527-2 ²
Tensile Strain			
Yield		5.0 %	ISO 527-2 ²
Break		35 %	ASTM D638
Nominal strain at break		28 %	ISO 527-2 ²
Flexural Modulus		1960 MPa	ASTM D790
Flexural Strength		66.9 MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Charpy notched impact strength			ISO 179/1eA ²
-30°C		3.90 kJ/m ²	
23°C		50.2 kJ/m ²	
Charpy impact strength			ISO 179/1eU ²
-30°C		42.2 kJ/m ²	
23°C		No Break	
Notched Izod Impact			ASTM D256
23°C, 3.18 mm		395 J/m	
23°C, 6.35 mm		294 J/m	

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)		95	ASTM D785

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed		91.1 °C	
Glass Transition Temperature ³		110 °C	ISO 11357-2 ²
Vicat Softening Temperature			
--		103 °C	ASTM D1525
50°C/h, B (50N)		93.8 °C	ISO 306 ²
CLTE			ISO 11359-2 ²
Flow		0.000094 cm/cm/°C	
Transverse		0.000094 cm/cm/°C	

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 www.kedisujiao.com

备注：以上原料物性数据由IDES发布, 我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

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Flammability	Nominal Value	Unit	Test Method
Flame Rating - UL			UL 94
1.59 mm		HB	
3.18 mm		HB	
Burning Behav. at thickness h (3.20 mm, UL)		HB	ISO 1210 ²

Additional Information
Melt Flow Rate, ASTM D1238, 200°C/5kg: 0.6 g/10min
Melt Flow Rate, ASTM D1238, 230°C/3.8kg: 2.0 g/10min

Extrusion	Nominal Value	Unit
Drying Temperature	85.0 to 95.0	°C
Drying Time	2.0 to 3.0	hr
Suggested Max Moisture	0.10	%
Cylinder Zone 1 Temp.	190 to 210	°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
Cylinder Zone 5 Temp.	210 to 230	°C
Adapter Temperature	210 to 230	°C
Die Temperature	210 to 250	°C
Take-Off Roll	70.0 to 100	°C
Back Pressure	0.0867 to 0.1000	MPa

Extrusion Notes
Flange temp: 210 to 230°C

Notes

- ¹ Typical properties: these are not to be construed as specifications.
² Tested in accordance with ISO 10350. 23°C/50%r.h. unless otherwise noted.
³ 10 °C/min

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