

ASA LI931

Extrusion Molding

Description

Low Gloss, Extrusion

Application

Industrial Materials (Window Profile, Tile Etc)

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℃/10kg	ASTM D1238	g/10min	7
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	330
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	
@ Break	50mm/min		%	65
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm ²	500
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm ²	15,500
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23℃		kg-cm/cm	9
	-30℃		kg-cm/cm	4
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg-cm/cm	10
	-30℃		kg-cm/cm	5
Rockwell Hardness	R-Scale	ASTM D785	-	81
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	79
	4.6kg		℃	85
Vicat Softening Temperature		ASTM D1525		
	5kg, 50℃/h		℃	86
Flammability		UL94		
Relative Temperature Index		UL 746B		
Electrical			℃	
Mechanical with Impact			℃	
Mechanical without Impact			℃	
Optical				
Gloss	45°	ASTM D2457	-	30.0

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℃, 50% relative humidity.

Updated : 29-Jul-14

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.

ASA LI931

Extrusion Molding

Description

Low Gloss, Extrusion

Application

Industrial Materials (Window Profile, Tile Etc)

Processing Guide (Extrusion Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	70 ~ 80
Drying Time	hrs	3 ~ 4
Minimum Moisture Content	%	0.01
Melt Temperature	°C	200 ~ 250
Barrel Temperature	Zone 1	°C 180 ~ 210
	Zone 2	°C 190 ~ 230
	Zone 3	°C 200 ~ 250
	Zone 4	°C 200 ~ 250
Adapter Temperature	°C	200 ~ 250
Die Temperature	°C	200 ~ 250
Roll Stack Temperature	Top	°C 70 ~ 100
	Middle	°C 70 ~ 90
	Bottom	°C 60 ~ 90

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

Updated : 29-Jul-14

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.