SolutionPartner

LG Chem

ASA LI951

Injection Molding Grade

Description

High Heat ASA

Application

Automotive Part (Radiator Grill, Side Mirror)

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	6
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm^2	510
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	
@ Break	50mm/min		%	25
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm^2	
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm^2	790
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm^2	22,000
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	11
	-30℃		kg·cm/cm	
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	12
	-30℃		kg·cm/cm	
Rockwell Hardness	R-Scale	ASTM D785	-	106
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	95
	4.6kg		℃	104
Vicat Softening Temperature		ASTM D1525		
	5kg, 50℃/h		℃	104
Flammability		UL94		HB
Relative Temperature Index		UL 746B		
Electrical			℃	
Mechanical with Impact			℃	
Mechanical without Impact			℃	
Optical				
Gloss	45°	ASTM D2457	-	

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 molulded specimens and after 48 hours storage at 23℃, 50% relative humidty.

Updated : 28-Dec-11

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	70 ~ 80
Drying Time		hrs	3 ~ 4
Minimum Moisture Content		%	0.01
Melt Temperature		℃	210 ~ 240
Cylinder Temperature	Rear	℃	200 ~ 220
	Middle	℃	210 ~ 230
	Front	℃	220 ~ 240
Nozzle Temperature		℃	220 ~ 240
Mold Temperature		℃	40 ~ 60
Back Pressure		kg/cm^2	700 ~ 900
Screw Speed		rpm	under 80

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.
These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

Updated : 28-Dec-11