

EnVoy 0503

ASA



| Product Description | | | | | |
|--|---------------------------------------|----------------|----------|----------------|---------|
| Molding Grade ASA | | | | | |
| General Properties | | | | | |
| Appearance | Black, Natural, Colors | | | | |
| Processing Methods | Injection Molding | | | | |
| Applications | Automotive, Industrial, Lawn & Garden | | | | |
| Mechanical Properties | Test Method | English Units | | S.I. Units | |
| Tensile Strength @ Yield | ASTM D638 | 6,000 | psi | 41 | MPa |
| Tensile Elongation at Break | ASTM D638 | 4 | % | 4 | % |
| Flexural Modulus | ASTM D790 | 325,000 | psi | 2,241 | MPa |
| Flexural Strength | ASTM D790 | 10,500 | psi | 72 | MPa |
| Notched Izod Impact (73°F) | ASTM D256 | 3.0 | ft-lb/in | 160 | J/m |
| Physical Properties | Test Method | English Units | | S.I. Units | |
| Specific Gravity | ASTM D792 | 1.04 | sp gr | 1.04 | sp gr |
| Melt Flow 230°C/3.8 kg | ASTM D1238 | 5.0 | g/10min | 5.0 | g/10min |
| Melt Flow 220°C/10 kg | ASTM D1238 | 12.0 | g/10min | 12.0 | g/10min |
| Mold Shrink - Flow: 0.126 in (3.20 mm) | ASTM D955 | 0.004 to 0.007 | in/in | 0.004 to 0.007 | % |
| Mold Shrink -XFlow: 0.126 in (3.20 mm) | ASTM D955 | 0.004 to 0.007 | in/in | 0.004 to 0.007 | % |
| Thermal Properties | Test Method | English Units | | S.I. Units | |
| Heat Deflection Temperature @ 264 psi | ASTM D648 | 180 | °F | 82 | °C |
| Injection Molding | | Value | | | |
| Drying Temperature | | 180 to 200 °F | °F | | |
| Drying Time | | 2.0 to 4.0 hr | hr | | |
| Maximum Drying Time | | 7.0 hr | hr | | |
| Suggested Maximum Moisture | | 0.10% | % | | |
| Rear Barrel Temperatures | | 370 to 450 °F | °F | | |
| Middle Barrel Temperatures | | 400 to 475 °F | °F | | |
| Front Barrel Temperatures | | 425 to 500 °F | °F | | |
| Nozzle Temperature | | 425 to 525 °F | °F | | |
| Melt (processing) Temperatures | | 425 to 525 °F | °F | | |
| Mold Temperatures | | 120 to 170 °F | °F | | |
| Back Pressure | | 25 to 100 psi | psi | | |
| Screw speed | | 25 to 75 rpm | rpm | | |

These Data Sheet Values are Typical Values and are not intended for specification purposes. These values should only be used as a guide and no assurances by EnCom, Inc. can be granted that all molded articles will exhibit duplicate properties as those listed above. Each material user should perform their own testing for suitability.

EnCom Polymers, Inc.

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