

EnVoy 0506

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	6.0	ft-lb/in	320	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.

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