

Technical Data Sheet

XC811-HW

ASA

PRODUCT DESCRIPTION:

ASAXC811-HW is a type of high heat-resistance grade of ASA resin, with high rigidity and toughness. Application: automotive exteriors like radiator grille, pillar board, rearview mirror, licence plate board, etc.

FEATURES:

- High heat-resistance grade
- Good weather ability

APPLICATION:

- Radiator grille
- Antenna shell

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	23°C	g/cm ³	1.09
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.4-0.7
Mechanical				
Tensile Strength	ISO 527	50mm/min	MPa	50
Tensile Elogation at Break	ISO 527	50mm/min	%	20
Flexural Strength	ISO 178	2mm/min	MPa	65
Flexural Modulus	ISO 178	2mm/min	MPa	2100
Notched Charpy Impact	ISO 179	4J, 23°C	kJ/m ²	13
Notched Charpy Impact	ISO 179	4J, -30°C	kJ/m ²	2.5
Unnotched Charpy Impact	ISO 179	4J, 23°C	kJ/m ²	NB
Rockwell Hardness	ISO 2039	R-scale	—	110
Thermal				
Heat Deflection Temperature	ISO 75	120°C/hr, 0.45MPa	°C	96
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	85
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	102
Other Properties				
Flammability	ISO 3795	360*100*3 mm	mm/min	≤80

Processing Parameters		Value	Unit
Pre-treatment			
Drying Temperature		80 ~ 95	°C
Drying Time		3 ~ 4	hour
Maximum Moisture Content		≤0.05	%
General Guidelines			
Barrel Temperature	Rear	200 ~ 220	°C
	Middle	230 ~ 240	°C
	Front	245 ~ 260	°C
Nozzle		240 ~ 250	°C
Melt Temperature		240 ~ 260	°C
Mold Temperature		50 ~ 80	°C

Note :

1. Values are measured at 23°C and in RH of 50% on injection molded specimens.
2. Typical values for uncolored products, not specifications, and may vary slightly with different colors.
3. Flexural strength is tested with fixed deflection.
4. HDT: specimens are unannealed.
5. The general guidelines are only for reference. Exact settings have to follow the product and machine conditions.

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