

MA-90309M

ASA Compound

Product Description

MA-90309M is used in co-extrusion and extrusion molding applications. The key benefits of this material is that it provides great weather-resistance ability and has great fluidity thus providing equal and smooth application.

Typical Applications

Extruded outdoor purpose products including window profiles, door profiles, etc.

Typical data

Properties		Unit	Test Method	Value ⁽¹⁾
Physical				
Specific Gravity		g/cc	ASTM D792	1.08
Molding Shrinkage		%	ASTM D955	0.4~0.7
Melt Flow Index (220°C/10kg)		g/10min	ASTM D1238	7
Mechanical				
Tensile Strength (50mm/min)		kg/cm ²	ASTM D638	400
Tensile Modulus (1mm/min)		kg/cm ²	ASTM D638	17,000
Tensile Elongation Yield (50mm/min)		%	ASTM D638	6
Tensile Elongation Break (50mm/min)		%	ASTM D638	25
Flexural Strength (15mm/min)		kg/cm ²	ASTM D790	660
Flexural Modulus (15mm/min)		kg/cm ²	ASTM D790	20,500
IZOD Impact Strength (Notched)	1/4", 23°C	kg.cm/cm	ASTM D256	14
	1/4", -30°C	kg.cm/cm		4
	1/8", 23°C	kg.cm/cm		18
	1/8", -30°C	kg.cm/cm		4
Rockwell Hardness (R-Scale)		-	ASTM D785	98
Thermal				
Heat Deflection Temperature	18.5kg/cm ² , 1/4" (annealed)	°C	ASTM D648	90
	18.5kg/cm ² , 1/4" (unannealed)	°C		80
	4.6kg/cm ² , 1/4" (annealed)	°C		95
	4.6kg/cm ² , 1/4" (unannealed)	°C		89
Vicat Softening Temperature		°C	ASTM D1525	90
Flammability	1/8"	class	UL94	HB
	1/10"	class		
	1/16"	class		HB

(1) Typical values: not to be construed as specification limits

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Suggested Processing Condition

Sample 1. Korean Extruder

Item	Conditions	Comments
Drying		
Temperature	80°C	Varies depending on initial moisture content, dryer efficiency and relative humidity.
Time	> 4 hours	
Temperature Range		
Cylinder 1	165~175°C	Suggested for the reference. The range may vary slightly depending on the machine used for the process. Depending on the type of main resin used and the kind of final product (size, thickness, etc.), appropriate processing condition should be chosen for the best result.
Cylinder 2	170~180°C	
Cylinder 3	175~185°C	
Adapter	175~185°C	

*Conditions varies greatly depending on the Extruder machine.

Sample 2. Chinese Extruder

Item	Conditions	Comments
Drying		
Temperature	80°C	Varies depending on initial moisture content, dryer efficiency and relative humidity.
Time	> 4 hours	
Temperature Range		
Cylinder 1	195°C	Suggested for the reference. The range may vary slightly depending on the machine used for the process. Depending on the type of main resin used and the kind of final product (size, thickness, etc.), appropriate processing condition should be chosen for the best result.
Cylinder 2	190°C	
Cylinder 3	185°C	
Adapter	180°C	

*Conditions varies greatly depending on the Extruder machine.