

ColorFast® ASA-PC130

Americhem - Polycarbonate + ASA

General Information
Product Description

ASA-PC130 is a medium viscosity injection molding grade of acrylonitrile styrene acrylate + PC (ASA+PC) alloy with good chemical resistance and mechanical properties. It is suitable for a wide range of applications.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Excellent Colorability		
Uses	• Automotive Applications	• Household Goods	• Office Automation Equipment
	• Closures	• Housings	• Outdoor Applications
	• Consumer Applications	• Industrial Applications	
	• Engineering Parts	• Industrial Parts	
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.15		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	9000	psi	ASTM D638
Tensile Strength ² (Break)	7800	psi	ASTM D638
Flexural Modulus ²	365000	psi	ASTM D790
Flexural Strength ²	12800	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	6.0	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed, 0.126 in)	220	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	185	°F
Drying Time	3.0 to 4.0	hr
Suggested Shot Size	30 to 80	%
Rear Temperature	480 to 540	°F
Middle Temperature	490 to 550	°F
Front Temperature	550 to 565	°F
Nozzle Temperature	515 to 555	°F
Processing (Melt) Temp	505 to 565	°F
Mold Temperature	140 to 190	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

