Technical information

TEREZ® ASA 8010

High flow general standard grade.

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TER® GROUP

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TECHNICAL DATA SHEET

Product text

For all kinds of application with impact strength characteristics.

Properties	Value	Unit	Test method
Density	1,0600	g/cm³	ISO 1183
Hardness Rockwell R-scale	108		ASTM D785
Melt flow index (MFI)	18,00	g/10 min	ISO 1133
MFI Temperature	220	°C	ISO 1133
MFI Load	10,00	kg	ISO 1133
Impact strength Charpy (Notched 23°C), dry	12	kJ/m²	ISO 179
Impact strength Charpy (Notched -30°C), dry	4	kJ/m²	ISO 179
Impact strength Charpy 23°C, dry	190	kJ/m²	ISO 179
Impact strength Charpy -30°C, dry	90	kJ/m²	ISO 179
Elongation at tear, dry	12	%	ISO 527
Tensile stress at yield, dry	47	MPa	ISO 527
Flexural Modulus	2300	MPa	ISO 178
Flexural strength, dry	70	MPa	ISO 178
Tensile-modulus, dry	2200	MPa	ISO 527
Tensile strength, dry	59	MPa	ISO 527
HDT 0,45 MPa	101	°C	ISO 75
HDT 1,80 MPa	85	°C	ISO 75
Vicat B/50	97	°C	ISO 306
Coeff. of linear therm. expansion (parallel)	0,8 - 1,1	E-4/°C	ISO 11359-1/-2
Coeff. of linear therm. expansion (normal)	0,8 - 1,1	E-4/°C	ISO 11359-1/-2
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94
Water absorption	0,45	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ ASA 8010

The processing data sheet provides guidelines about processing as well as pre-drying.

MATERIAL PREPARATION

Storage

Store in a dry place protected from direct sunlight. Avoid all sources of ignition like extreme heat, sparks, or open flame.

Drying

For the manufacturing of mechanically and optically optimal injection molding parts, we recommend following pre-drying conditions according to the table below. If the container is open (wet granules), the drying time can be extended accordingly.

Dry air dryer

Temperature	80°C
Time	4 hours
Due point	-40°C

Residual moisture

<= 0.1% (recommended)

MACHINE REQUIREMENTS

PROCESSING

Basic settings

Temperatures

Processing temperatures

Hopper	60 - 80°C
Center	220 - 240°C
Nozzle	230 - 250°C

Mold temperature

Temp.	40 - 80°C

Processing temperatures Extrusion

Hopper	180 - 200°C
Center	200 - 220°C
Nozzle	190 - 220°C

You should try to keep the residence time short, especially at high temperatures to avoid material degradation.

Instructions for cleaning

The aggregate can be cleaned by using low MFI polypropylene. You can also use standard cleaning granulate.