

Diamond Polymers ASA/PC TA-35

Category : Polymer , Thermoplastic , ASA Polymer , Polycarbonate (PC) , Polycarbonate/ASA Alloy, Unreinforced

Material Notes:

Description: ASA Weatherable Polymer, Injection Molding Grade, Very High Impact Information provided by Diamond Polymers, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Diamond-Polymers-ASAPC-TA-35.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.14 g/cc	1.14 g/cc	ASTM D792
Linear Mold Shrinkage	0.0040 - 0.0070 cm/cm	0.0040 - 0.0070 in/in	ASTM D955
Melt Flow	1.5 g/10 min	1.5 g/10 min	Procedure A Condition G; ASTM D1238
	@Load 5.00 kg, Temperature 200 °C	@Load 11.0 lb, Temperature 392 °F	
	7.0 g/10 min	7.0 g/10 min	Procedure A Condition I; ASTM D1238
	@Load 3.80 kg, Temperature 230 °C	@Load 8.38 lb, Temperature 446 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	102	102	ASTM D785
Tensile Strength, Yield	54.23 MPa	7866 psi	chs 2 in/min; ASTM D638
Flexural Modulus	2.41 GPa	350 ksi	Tangent, chs 0.05 in/min; ASTM D790
Izod Impact, Notched	5.34 J/cm	10.0 ft-lb/in	bar; ASTM D256
	@Thickness 3.17 mm, Temperature 23.0 °C	@Thickness 0.125 in, Temperature 73.4 °F	

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	98.3 °C	209 °F	0.125 in bar Unannealed/Conditioned 48 hours at 23°C; ASTM D648
Vicat Softening Point	130 °C	266 °F	0.125 inch, 1 Kg; ASTM D1525

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	229 - 260 °C	445 - 500 °F	
Middle Barrel Temperature	232 - 266 °C	450 - 510 °F	
Front Barrel Temperature	235 - 271 °C	455 - 520 °F	
Nozzle Temperature	221 - 271 °C	430 - 520 °F	

Processing Properties	Metric	English	Comments
Melt Temperature	221 - 271 °C	430 - 520 °F	Melt temperatures above 530 °F are not recommended, and may result in color shifts and or thermal instability.
Mold Temperature	37.8 - 82.2 °C	100 - 180 °F	Higher mold temperature can aid flow in processing, provides a better surface finish, and creates less residual stress in the finished products.
Drying Temperature	90.6 - 98.9 °C	195 - 210 °F	
Dry Time	2 - 4 hour	2 - 4 hour	
Moisture Content	<= 0.10 %	<= 0.10 %	
Back Pressure	0.517 - 1.03 MPa	75.0 - 150 psi	

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