Technical Data Sheet

Diamond Asa 2020 LG50

Acrylonitrile Styrene Acrylate
LyondellBasell Industries
Engineering Plastics

General		
Features	• Good Weather Resistance	• Medium Impact Resistance
Agency Ratings	• EC 1907/2006 (REACH)	• EU 2002/96/EC (WEEE)
RoHS Compliance	• RoHS Compliant	
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.06	1.06 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) [1] (220°c/10.0 Kg)	20 g/10 min	20 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength [2] (Yield)	6500 psi	44.8 MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	2.8 %	2.8 %	
Break	23 %	23 %	
Flexural Modulus - Tangent [3]	311000 psi	2140 MPa	ASTM D790
Flexural Strength	9400 psi	64.8 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact			ASTM D256
73°f (23°c), 0.125 In (3.18 Mm)	2.0 ft·lb/in	110 J/m	

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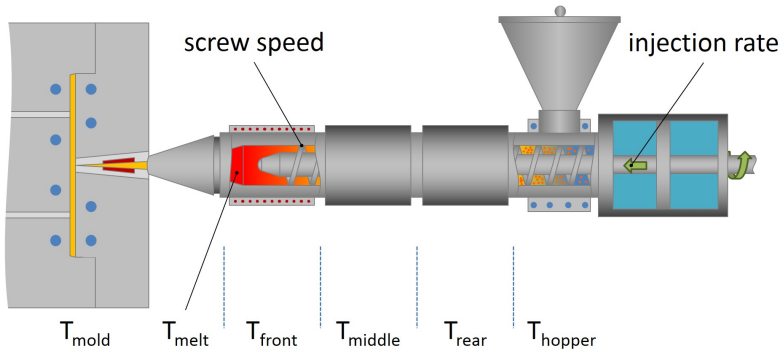

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 to 185 °F	80 to 85 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.10 %	0.10 %
Suggested Shot Size	40 to 70 %	40 to 70 %
Rear Temperature	446 to 500 °F	230 to 260 °C
Middle Temperature	450 to 509 °F	232 to 265 °C
Front Temperature	455 to 522 °F	235 to 272 °C
Nozzle Temperature	428 to 522 °F	220 to 272 °C
Processing (Melt) Temp	428 to 522 °F	220 to 272 °C
Mold Temperature	104 to 176 °F	40 to 80 °C
Injection Rate	Fast	Fast
Back Pressure	75.0 to 150 psi	0.517 to 1.03 MPa

Notes

[1] Procedure A

[2] 2.0 in/min (51 mm/min)

[3] 0.050 in/min (1.3 mm/min)

Notes

These are typical property values not to be construed as specification limits.