

MRC941D2

Description

High Heat ASA, Mechanical PCR ASA

Key Features

High Heat Resistance, Recycled ABS

Application

Automotive Part (Radiator Grill, Side Mirror & Pillar)

Properties	Condition	Method	Unit	MRC941D2
Physical				
MVR	(220°C, 10kg)	ISO1133	g/10min	6
Specific Gravity	23°C	ISO 1183		1.08
Mold Shrinkage	23°C, 3.2mm	ISO 294-4	%	0.4 ~ 0.7
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 4mm	ISO 527	MPa	47
Tensile Elongation at Break	23°C, 50mm/min, 4mm	ISO 527	%, (Min)	20
Flexural Strength	23°C, 2mm/min, 4mm	ISO 178	MPa	72
Flexural Modulus	23°C, 2mm/min, 4mm	ISO 178	MPa	2300
Izod Impact Strength	Notched, 4mm, 23°C	ISO 180/1A	kJ/m ²	10
Charpy Impact Strength	Notched, 4mm, 23°C	ISO 179/1eA	kJ/m ²	10
Rockwell Hardness	R-Scale	ISO 2039		103
Thermal				
Heat Deflection Temperature	Flatwise, 1.8MPa, 4mm, Unannealed	ISO 75	°C	86
Vicat Softening Temperature	50N, 50°C/h	ISO 306	°C	101

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.

Values given should not be interpreted as specification and not be used for designing part or tool.

All properties, except melt flow index are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80~90
Drying Time	hrs	3~4
Injection Temperature	°C	230~260
Mold Temperature	°C	40 ~ 80

Note

Injection Temperature & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.