

LI924

Description

LI924 is an ASA product for extrusion, designed to have good weatherability and high hardness.

Key Features

Weatherability, High Hardness, High Stiffness

Application

Deco Sheet

Properties	Condition	Method	Unit	LI924
Physical				
Specific Gravity	23°C	ASTM D792		1.07
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.7
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	9
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	57
Tensile Elongation at Break	23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	25
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	94
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	2800
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	80
Rockwell Hardness	R-Scale	ASTM D785		110
Thermal				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	92

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 (Extrusion)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Moisture Content	%	~ 0.01
Extrusion Temperature	°C	180 ~ 250

Note

Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.