

Technical Data Sheet

XC811

ASA

PRODUCT DESCRIPTION:

ASAXC811 is a type of high heat-resistance grade of ASA resin, with excellent weatherability, high rigidity and toughness. Application: automotive exteriors like radiator grille, pillar board, rearview mirror, licence plate board, etc.

FEATURES:

- High heat-resistance grade
- High rigidity

APPLICATION:

- Rearview mirror
- Radiator grille

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	23°C	g/cm ³	1.08
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.4-0.7
Melt Flow Rate	ISO 1133	220°C, 10kg	g/10 min	5
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	46
Elongation at Break	ISO 527	50mm/min	%	15
Flexural Strength	ISO 178	2mm/min	MPa	70
Flexural Modulus	ISO 178	2mm/min	MPa	2200
Notched Izod Impact	ISO 180	5.5J, 23°C	kJ/m ²	13
Notched Izod Impact	ISO 180	5.5J, -30°C	kJ/m ²	2
Unnotched Izod Impact	ISO 180	5.5J, 23°C	kJ/m ²	NB
Rockwell Hardness	ISO 2039	23°C	R-scale	105
Thermal				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	82
Heat Deflection Temperature	ISO 75	120°C/hr, 0.45MPa	°C	91
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	101
Other Properties				
Flammability	UL-94	1.6mm	—	HB

Processing Parameters		Value	Unit
Pre-treatment			
Drying Temperature		80 ~ 90	°C
Drying Time		3 ~ 4	hour
Maximum Moisture Content		≤0.05	%
General Guidelines			
Barrel Temperature	Rear	200 ~ 220	°C
	Middle	230 ~ 240	°C
	Front	245 ~ 260	°C
Nozzle		240 ~ 250	°C
Melt Temperature		240 ~ 260	°C
Mold Temperature		50 ~ 80	°C

Note :

1. Values are measured at 23°C and in RH of 50% on injection molded specimens.
2. Typical values for uncolored products, not specifications, and may vary slightly with different colors.

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