

Technical Data Sheet

Centrex ASA 810 000000NAT



Acrylonitrile Styrene Acrylate

Product Description

Centrex ASA 810 000000NAT is a Acrylonitrile Styrene Acrylate material and is typically used in Injection Molding applications. Features include: Good Processability, Good Weather Resistance, High Flow, High Gloss, and Medium Impact Resistance.

Regulatory Status

For regulatory compliance information, see ASA 810 000000NAT [Product Stewardship Bulletin \(PSB\)](#) and [Safety Data Sheet \(SDS\)](#).

Status	Commercial: Active
Availability	North America
Processing Method	Injection Molding
Attribute	Good Processability; Good Weather Resistance; High Flow; High Gloss; Medium Impact Resistance
Forms	Pellets
Application	Outdoor Applications

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (220 °C/10.0 kg)	21	g/10 min	ASTM D1238
Density - Specific Gravity	1.06	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield, (5.1 mm/min)	40.7	MPa	ASTM D638
Flexural Modulus, (1.3 mm/min, Tangent)	2390	MPa	ASTM D790
Tensile Modulus, (5.1 mm/min)	2460	MPa	ASTM D638
Flexural Strength, (1.3 mm/min)	70.3	MPa	ASTM D790
Impact			
Instrumented Dart Impact			
(23 °C, Total Energy)	45.0	J	ASTM D3763
(-30 °C, Total Energy)	10.0	J	ASTM D3763
(0 °C, Total Energy)	40.0	J	ASTM D3763
Notched Izod Impact			
(23 °C, 3.18 mm)	85	J/m	ASTM D256
(-30 °C, 3.18 mm)	53	J/m	ASTM D256
(0 °C, 3.18 mm)	64	J/m	ASTM D256
Hardness			
Rockwell Hardness, (R-Scale)	100		ASTM D785
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)			
(3.18 mm)	74.0	°C	ASTM D648
(6.35 mm)	80.0	°C	ASTM D648



Injection Parameters	Nominal Value	Units
Drying Time, (Desiccant Dryer)	2.0	hr
Drying Temperature, (Desiccant Dryer)	82 to 88	°C
Dew Point, (Desiccant Dryer)	-29	°C
Suggested Max Moisture	0.1	%
Nozzle Temperature	238 to 271	°C
Processing (Melt) Temp	238 to 271	°C
Front Temperature	238 to 271	°C
Screw L/D Ratio	20.0-1.0	
Screw Compression Ratio	2.5-1.0	
Suggested Shot Size	50 to 70	%
Middle Temperature	238 to 271	°C
Rear Temperature	238 to 271	°C
Injection Rate	Moderate	
Mold Temperature	43 to 82	°C

Notes

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

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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