

## Technical Data Sheet

### *Diamond* ASA S225LG 6428 UVORE



Acrylonitrile Styrene Acrylate

#### Product Description

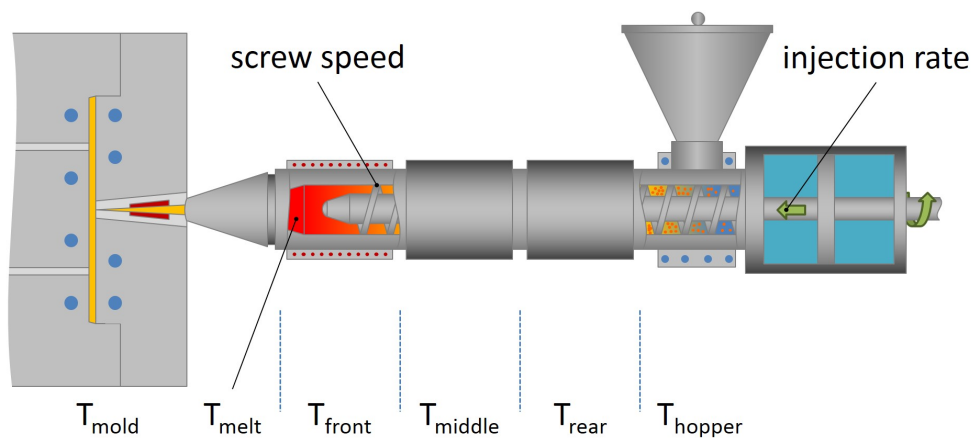
*Diamond* ASA S225LG 6428 UVORE is a Acrylonitrile Styrene Acrylate material and is typically used in Injection Molding applications. Features include: Good Weather Resistance, and Low Fogging.

#### Regulatory Status

For regulatory compliance information, see ASA S225LG 6428 UVORE [Product Stewardship Bulletin \(PSB\)](#) and [Safety Data Sheet \(SDS\)](#).

|                          |                                      |
|--------------------------|--------------------------------------|
| <b>Status</b>            | Commercial: Active                   |
| <b>Availability</b>      | North America                        |
| <b>Processing Method</b> | Injection Molding                    |
| <b>Attribute</b>         | Good Weather Resistance; Low Fogging |
| <b>Forms</b>             | Pellets                              |

| Typical Properties                                                                  | Nominal Value | Units             | Test Method |
|-------------------------------------------------------------------------------------|---------------|-------------------|-------------|
| <b>Physical</b>                                                                     |               |                   |             |
| Melt Flow Rate, (220 °C/10.0 kg)                                                    | 11            | g/10 min          | ASTM D1238  |
| Density - Specific Gravity                                                          | 1.07          | g/cm <sup>3</sup> | ASTM D792   |
| <b>Mechanical</b>                                                                   |               |                   |             |
| Tensile Elongation at Yield, (51 mm/min, 23 °C, 3.18 mm, Injection Molded, Type I)  | 3.2           | %                 | ASTM D638   |
| Tensile Strength at Yield, (51 mm/min, 23 °C, 3.18 mm, Injection Molded, Type I)    | 42.7          | MPa               | ASTM D638   |
| Tensile Strength at Break, (51 mm/min, 23 °C, 3.18 mm, Injection Molded, Type I)    | 37.9          | MPa               | ASTM D638   |
| Tensile Elongation at Break, (51 mm/min, 23 °C, 3.18 mm, Injection Molded, Type I)  | 42            | %                 | ASTM D638   |
| <b>Impact</b>                                                                       |               |                   |             |
| Notched Izod Impact, (23 °C, 3.18 mm, Injection Molded)                             | 81            | J/m               | ASTM D256   |
| <b>Thermal</b>                                                                      |               |                   |             |
| Vicat Softening Temperature, (Loading 1 (10 N))                                     | 105           | °C                | ASTM D1525  |
| Deflection Temperature Under Load Unannealed (264 psi), (3.18 mm, Injection Molded) | 77.2          | °C                | ASTM D648   |



| Injection Parameters   | Nominal Value | Units |
|------------------------|---------------|-------|
| Drying Time            | 2.0 to 4.0    | hr    |
| Drying Temperature     | 80 to 85      | °C    |
| Suggested Max Moisture | 0.02          | %     |
| Nozzle Temperature     | 220 to 260    | °C    |
| Processing (Melt) Temp | 220 to 260    | °C    |
| Front Temperature      | 235 to 260    | °C    |
| Suggested Shot Size    | 40 to 70      | %     |
| Middle Temperature     | 232 to 260    | °C    |
| Rear Temperature       | 230 to 260    | °C    |
| Injection Rate         | Fast          |       |
| Back Pressure          | 0.517 to 1.03 | MPa   |
| Mold Temperature       | 71 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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