Technical Data Sheet

Centrex 485CS

Acrylonitrile Styrene Acrylate
LyondellBasell Industries
Engineering Plastics

General			
Features	• Good Melt Strength • Good Weather Resistance	• Low Gloss • Medium Impact Resistance	• UV Resistant
Uses	• Automotive Applications • Automotive Exterior Parts	• Automotive Exterior Trim • Automotive Interior Parts	• Outdoor Applications
Agency Ratings	• EC 1907/2006 (REACH)	• EU 2002/96/EC (WEEE)	
RoHS Compliance	• RoHS Compliant		
UL File NumberUsa	• E150937		
Forms	• Pellets		
Processing Method	• Coextrusion	• Extrusion	• Thermoforming

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity			
--	1.06	1.06 g/cm³	ASTM D792
73°f (23°c)	1.07 g/cm³	1.07 g/cm³	ISO 1183/A
Melt Mass-Flow Rate (MFR)			
220°c/10.0 Kg	5.0 g/10 min	5.0 g/10 min	ASTM D1238
220°c/10.0 Kg	6.1 g/10 min	6.1 g/10 min	ISO 1133
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus [1]	210000 psi	1450 MPa	ASTM D638
Tensile Strength [1] (Yield)	3850 psi	26.5 MPa	ASTM D638
Flexural Modulus - Tangent [2]	200000 psi	1380 MPa	ASTM D790
Flexural Strength [2]	5600 psi	38.6 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact			ASTM D256
-40°f (-40°c), 0.125 In (3.18 Mm)	0.80 ft·lb/in	43 J/m	
0°f (-18°c), 0.125 In (3.18 Mm)	1.2 ft·lb/in	64 J/m	
73°f (23°c), 0.125 In (3.18 Mm)	2.4 ft·lb/in	130 J/m	
Instrumented Dart Impact			ASTM D3763
-22°f (-30°c), Total Energy	53.1 in·lb	6.00 J	
0°f (-18°c), Total Energy	142 in·lb	16.0 J	
73°f (23°c), Total Energy	212 in·lb	24.0 J	
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Rockwell Hardness (R-scale)	69	69	ASTM D785
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 Psi (1.8 Mpa), Unannealed, 0.125 In (3.18 Mm)	155 °F	68.3 °C	
Vicat Softening Temperature	212 °F	100 °C	ASTM D1525
CLTE - Flow	5.2E-5 in/in/°F	9.4E-5 cm/cm/°C	ASTM D696
Flammability	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Flame Rating (0.06 In (1.5 Mm))	HB	HB	UL 94
Optical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Gloss			ASTM D523
60° [3]	20	20	
60° [4]	10	10	

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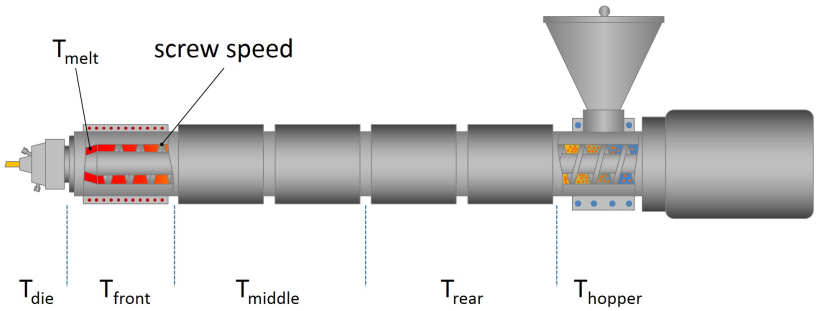

Extrusion	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	180 to 200 °F	82 to 93 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	< 0.03 %	< 0.03 %
Suggested Max Regrind	40 %	40 %
Melt Temperature	400 to 470 °F	204 to 243 °C
Die Temperature	410 to 465 °F	210 to 241 °C

Extrusion Notes

Polish roll Top: Down stack 200°F, Up stack 200°F
Polish roll Middle: Down stack 165°F, Up stack 190°F
Polish roll Bottom: Down stack 200°F, Up stack 180°F

Notes

[1] 0.20 in/min (5.1 mm/min)

[2] 0.050 in/min (1.3 mm/min)

[3] Sheet

[4] Formed

Notes

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