

Technical Data Sheet

Diamond Asa S510

Acrylonitrile Styrene Acrylate
LyondellBasell Industries
Engineering Plastics

General			
Features	• Good Weather Resistance • Medium Impact Resistance		
Agency Ratings	• EC 1907/2006 (REACH) • EU 2002/96/EC (WEEE)		
RoHS Compliance	• RoHS Compliant		
UL File Number	• E150937		
Forms	• Pellets		
Processing Method	• Injection Molding		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.06	1.06 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (230°C/3.8 Kg)	6.5 g/10 min	6.5 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength ² (Yield)	6400 psi	44.1 MPa	ASTM D638
Flexural Modulus - Tangent ³	330000 psi	2280 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.125 In (3.18 Mm)	2.5 ft·lb/in	130 J/m	
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)	181 °F	82.8 °C	
Vicat Softening Temperature	198 °F	92.2 °C	ASTM D1525 ⁴
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 In (1.5 Mm))	HB	HB	UL 94

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 to 185 °F	80 to 85 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.10 %	0.10 %
Suggested Shot Size	40 to 70 %	40 to 70 %
Rear Temperature	446 to 500 °F	230 to 260 °C
Middle Temperature	450 to 509 °F	232 to 265 °C
Front Temperature	455 to 522 °F	235 to 272 °C
Nozzle Temperature	428 to 522 °F	220 to 272 °C
Processing (Melt) Temp	428 to 522 °F	220 to 272 °C
Mold Temperature	104 to 176 °F	40 to 80 °C
Injection Rate	Fast	Fast
Back Pressure	75.0 to 150 psi	0.517 to 1.03 MPa

Notes

¹ Procedure A

² 2.0 in/min (51 mm/min)

³ 0.050 in/min (1.3 mm/min)

⁴ Loading 1 (10 N)

Notes

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