

## Optilac ASA134U

The Materials Group - Acrylonitrile Styrene Acrylate

### General Information

#### General

Material Status	• Commercial: Active
Availability	• North America
Features	• Good Weather Resistance • Terpolymer • High Gloss • UV Resistant
Uses	• Automotive Applications • Automotive Exterior Parts • Automotive Interior Parts
Appearance	• Black • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	9.5	g/10 min	ISO 1133
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	290000	psi	ISO 527-1
Tensile Stress (Yield)	6240	psi	ISO 527-2
Flexural Modulus	290000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	5.3	ft·lb/in <sup>2</sup>	ISO 179

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	194 to 203	°F
Drying Time	3.0	hr
Rear Temperature	446 to 482	°F
Middle Temperature	464 to 500	°F
Nozzle Temperature	464 to 500	°F
Mold Temperature	105 to 175	°F
Injection Pressure	711 to 996	psi
Holding Pressure	569 to 853	psi
Back Pressure	71.0 to 213	psi

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

