

MA301-M

(PVC+ASA)

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	15	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0045	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	52	MPa	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	65	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact unnotched, 1/8 in	40	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	83	°C	ASTM D 648
Vicat Temperature	95	°C	ASTM D 1525

Electrical properties	Value	Unit	Test Standard
ISO Data			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Density	1120	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 85	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	185 - 195	°C	-
Mold temperature	60 - 80	°C	-
Zone 1	170 - 180	°C	-
Zone 2	185 - 190	°C	-
Zone 3	190 - 195	°C	-
Nozzle temperature	185 - 190	°C	-
Screw speed	30 - 50	rpm	-
Back pressure	1 - 5	MPa	-

Characteristics**Processing**

Other Extrusion

Chemical Resistance

General Chemical Resistance

Special Characteristics

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

Regional Availability

Asia Pacific