

**Stylac A3921**

ABS

Asahi Kasei

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	<b>11</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
Melt flow index, MFI	<b>10</b>	g/10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
<b>ASTM Data</b>			
Mold Shrinkage, MD	<b>0.006</b>	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Yield stress	<b>52</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>2750</b>	MPa	ISO 178
Flexural strength	<b>82</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>9</b>	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>94</b>	°C	ISO 75-1/-2
Vicat softening temperature, B	<b>113</b>	°C	ISO 306
<b>ASTM Data</b>			
UL 94 Flame rating	<b>HB</b>	-	UL 94
Thickness tested	<b>1.5</b>	mm	-

Other properties	Value	Unit	Test Standard
Density	<b>1070</b>	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>75 - 90</b>	°C	-
Pre-drying - Time	<b>3 - 4</b>	h	-
Mold temperature	<b>40 - 70</b>	°C	-
Zone 1	<b>200 - 240</b>	°C	-
Zone 2	<b>220 - 260</b>	°C	-
Zone 3	<b>220 - 270</b>	°C	-
Nozzle temperature	<b>220 - 250</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Special Characteristics**

Heat stabilized or stable to heat