

Technical Data Sheet

HNA0380

PA/ASA

PRODUCT DESCRIPTION:

PA/ASAHNA0380 is an PA6/ASA blend combining high heat-resistance and weather resistance with an excellent processability and surface appearance.

FEATURES:

- Excellent anti-scratch performance
- High heat-resistance

APPLICATION:

- Automobile parts

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	DIN EN ISO 1183	23°C	g/cm ³	1.11
Mold Shrinkage	DIN EN ISO 294	23°C, 48hr	%	0.6 ~ 0.8
Melt Flow Rate	DIN EN ISO 1133	240°C, 10kg	g/10 min	50
Mechanical				
Tensile Strength at Yield	DIN EN ISO 527	50mm/min	MPa	55
Tensile Modulus	DIN EN ISO 527	1mm/min	MPa	2000
Flexural Strength	DIN EN ISO 178	2mm/min	MPa	66
Notched Charpy Impact	DIN EN ISO 179	4J, 23°C	kJ/m ²	20
Unnotched Charpy Impact	DIN EN ISO 179	4J, 23°C	kJ/m ²	NB
Thermal				
Vicat Softening Temperature	DIN EN ISO 306	50°C/hr, 5kg	°C	125
Other Properties				
Flammability	UL 94	1.50 mm	mm/min	HB

Processing Parameters		Value	Unit
Pre-treatment			
Drying Temperature		85 ~ 100	°C
Drying Time		3 ~ 4	hour
Maximum Moisture Content		≤0.02	%
General Guidelines			
Barrel Temperature	Rear	190 ~210	°C
	Middle	210 ~ 230	°C
	Front	210 ~ 230	°C
Nozzle		220 ~ 240	°C
Melt Temperature		220 ~ 230	°C
Mold Temperature		60 ~ 90	°C

Note :

1. Values are measured at 23°C and in RH of 50% on injection molded specimens.
2. Typical values for uncolored products, not specifications, and may vary slightly with different colors.
3. Flexural strength is tested with fixed deflection.
4. HDT: specimens are unannealed.
5. The general guidelines are only for reference. Exact settings have to follow the product and machine conditions.

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