

Technical Data Sheet

HNA0370

PA/ASA

PRODUCT DESCRIPTION:

PA/ASAHNA0370 is an PA6/ASA blend combining good impact strength, weather resistance, excellent processability and surface appearance.

FEATURES:

- Good processability
- Low gloss

APPLICATION:

- IP Cluster trim and bezel
- Speaker grill

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	23°C	g/cm ³	1.08
Mold Shrinkage (3mm)	ISO 294	23°C, 48hr	%	0.6-0.8
Melt Flow Rate	ISO 1133	240°C, 10kg	g/10min	60
Poisson's Ratio	ISO 527	1mm/min	—	0.38
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	50
Flexural Strength	ISO 178	2mm/min	MPa	67
Flexural Modulus	ISO 178	2mm/min	MPa	2000
Notched Charpy Impact	ISO 179	4J, 23°C	kJ/m ²	50
Unnotched Charpy Impact	ISO 179	4J, 23°C	kJ/m ²	NB
Thermal				
Heat Deflection Temperature	ISO 75	120°C/hr, 0.45MPa	°C	92
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	110
Other Properties				
Flammability	ISO 3795	355x100x3 mm	mm/min	≤100

Processing Parameters		Value	Unit
Pre-treatment			
Drying Temperature		80 ~ 90	°C
Drying Time		3 ~ 4	hour
Maximum Moisture Content		≤0.05	%
General Guidelines			
Barrel Temperature	Rear	190 ~ 220	°C
	Middle	220 ~ 240	°C
	Front	220 ~ 240	°C
Nozzle		230 ~ 255	°C
Melt Temperature		230 ~ 250	°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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