

Properties

090, 090SF

SAN resin

Heat resistance

Properties	Test methods	Test conditions	Units	
Melt mass-flow rate	ISO 1133	220 deg C/10kg	g/10min	23
Mold shrinkage	Daicel method	-	%	0.3-0.5
Tensile strength	ISO 527	-	MPa	77
Flexural strength	ISO 178	-	MPa	130
Flexural modulus	ISO 178	-	MPa	3700
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	2
Rockwell hardness	ISO 2039	-	-	M80
Deflection temperature under load	ISO 75	1.80MPa	deg C	87
Vicat softening temperature	ISO 306/B50	50N X 50deg C/h	deg C	104
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	7
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	-
Water absorption	ISO 62	-	%	0.3
Density	ISO 1183	-	g/cm3	1.08

Note

•Values are typical, not quality assured.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
3-5hrs 80-85deg C	210-230	210-230	190-210	170-190	70-90	10-20	40-60