



KIBILAC® PW-978B

CHI MEI CORPORATION - Acrylonitrile Styrene Acrylate

Sunday, November 3, 2019

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• High Heat Resistance		
RoHS Compliance	• RoHS Compliant		
Resin ID (ISO 1043)	• >ASA<		

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity ²	1.07		ASTM D792
Density (73°F)	1.07	g/cm ³	ISO 1183
Melt Mass-Flow Rate (220°C/10.0 kg)	13	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	12	cm ³ /10min	ISO 1133
Molding Shrinkage	0.40 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ³ (Yield)	6670	psi	ASTM D638
Tensile Stress (Yield)	6820	psi	ISO 527-2/50
Tensile Stress (Break)	4930	psi	ISO 527-2/50
Tensile Elongation ³ (Break)	55	%	ASTM D638
Tensile Strain (Break)	20	%	ISO 527-2/50
Flexural Modulus ⁴	327000	psi	ASTM D790
Flexural Modulus ⁵	305000	psi	ISO 178
Flexural Strength ⁴	9610	psi	ASTM D790
Flexural Stress ⁵	9720	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-22°F	2.9	ft·lb/in ²	
73°F	5.9	ft·lb/in ²	
Notched Izod Impact			ASTM D256
73°F, 0.126 in	3.8	ft·lb/in	
73°F, 0.252 in	3.6	ft·lb/in	
Notched Izod Impact Strength			ISO 180/1A
-22°F	2.4	ft·lb/in ²	
73°F	5.7	ft·lb/in ²	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	187	°F	ISO 75-2/A
Heat Deflection Temperature (264 psi, Annealed)	221	°F	ISO 75-2/A
Vicat Softening Temperature	235	°F	ASTM D1525 ⁶

KIBILAC® PW-978B

CHI MEI CORPORATION - Acrylonitrile Styrene Acrylate

Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature			
--	234	°F	ISO 306/A50
--	212	°F	ISO 306/B50
CLTE - Flow	5.1E-5	in/in/°F	ISO 11359-2
Heat Deflection Temperature			ASTM D648
Annealed	217	°F	
Unannealed	199	°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	194 to 203	°F
Drying Time	3.0	hr
Rear Temperature	446 to 482	°F
Middle Temperature	464 to 500	°F
Front Temperature	464 to 500	°F
Mold Temperature	104 to 176	°F
Injection Pressure	711 to 996	psi
Holding Pressure	569 to 853	psi
Back Pressure	71.1 to 213	psi

Notes

¹ Typical properties: these are not to be construed as specifications.

² 23°C

³ 0.24 in/min

⁴ 0.11 in/min

⁵ 0.079 in/min

⁶ Rate A (50°C/h), Loading 1 (10 N)