



14030 Gannet Street, Santa Fe Springs, CA 90670

Phone: (562) 921-0444 Fax: (562) 921-0034

## Processing Guidelines

**Material:** *Acrylonitrile - Styrene - Acrylate (ASA) Resin*

### **GENERAL INJECTION MOLDING PROCESSING GUIDELINES**

<b>Property</b>	<b>Data</b>	<b>Units</b>
Drying Temperature	180 - 200	°F
Drying Time	2.0 - 3.0	hr
Drying Time, Maximum	4.0	hr
Injection Pressure	10000 - 12000	psi
Suggested Max Regrind	20.0	%
Rear Temperature	370 - 410	°F
Middle Temperature	400 - 440	°F
Front Temperature	410 - 460	°F
Nozzle Temperature	410 - 460	°F
Mold Temperature	104 - 140	°F

THE ABOVE DATA IS TO BE USED SOLELY AS AN APPROXIMATE GUIDELINE AND IS SUBJECT TO CHANGE WITHOUT NOTICE. SOUTHLAND POLYMERS INC. ASSUMES NO LIABILITY FOR THE ACCURACY, COMPLETENESS, OR VALIDITY OF INFORMATION CONTAINED HEREIN. MATERIAL APPLICATION, PERFORMANCE, AND SUITABILITY MUST BE DETERMINED INDEPENDENTLY BY THE END USER. ALL PRODUCT TRADEMARKS USED ARE PROPERTY OF THEIR RESPECTIVE OWNERS. PLEASE CONTACT YOUR ACCOUNT MANAGER OR SOUTHLAND POLYMERS TECHNICAL SUPPORT FOR ALL QUESTIONS REGARDING OUR PRODUCTS.