

LI935

Description

LI935 is an ASA with improved surface quality designed for metallized rear lamp housings

Key Features

Standard Purpose, Vacuum evaporation, Weatherability,
Superior Surface Quality, Metallization

Application

Rear Combination Lamp

Properties	Condition	Method	Unit	LI935
Physical				
Specific Gravity	23°C	ASTM D792		1.08
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.6
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	13
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	600
Tensile Elongation at Break	23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	17
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	960
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	28000
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	6
Rockwell Hardness	R-Scale	ASTM D785		112
Thermal				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	98
Vicat Softening Temperature	50N, 50°C/h	ASTM D1525	°C	109

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.

Values given should not be interpreted as specification and not be used for designing part or tool.

All properties, except melt flow index are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	70 ~ 90
Drying Time	hrs	3 ~ 4
Injection Temperature	°C	240 ~260
Mold Temperature	°C	40 ~ 80
Screw Speed	rpm	20 ~ 70

Note

Injection Temperature & Screw Speed are only mentioned as general guidelines.
These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.