

ASA

(ACRYLONITRILE STYRENE
ACRYLATE)

1.75mm ± 0.02mm

DESCRIPTION

Amorphous Thermoplastic
Polymer, Hardness, UV,
Heat, Chemical resistance.



GST30
Global Solution Technology



APPLICATION

FDM PRINT Automotive industry
Commercial siding.

TESTED PRINT SETTING

BT	{C°}	80±10
NT	{C°}	255±15
SP	{mm/s}	250± 50
SF	{%}	80
RS	F/H	F/E

BT=Bed Temperature SF=Speed Fan
NT=Noozle Temperature RS=Retraction Speed
SP=Speed Print F/H=For Hoten

MATERIAL PROPERTIES

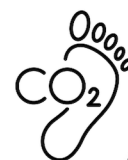
Density	1.00cm ³
Humidity Absorbption	0.15%
Temp Thermic Deflec (1.80 MPa)	85
Hardness "D" scale	82
Interlayer adhesion	[MPa] 10 ± 2

MECHANICAL SPECS

Tensile strenght	50mm/s
Tensile modulus	1mm/min
Flexural strenght	16mm/min
Impact strenght	22°c -32°c
Rockwell strenght	102

THERMAL PROPERTY

HDT (0.45Mpa)	78°c
HDT (1.82Mpa)	72°
VST °	85°



TESTS METHODS ACCORDIND TO:

ISO1183; ISO1133; ISO527; ISO179; ISO75-2; DIN 53504-S2

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