



Technical Data Sheet Topolymer[®] ASA EL101

Application: Window profiles ,Canopy, Siding, Fence, (Roofing) Tiles
Grade: Co- extrusion

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ISO1183		1.07
Molding Shrinkage (Flow), 3.2mm		ISO294-4	%	0.3-0.7
Melt Flow Rate	220°C/10kg	ISO 1133	g/10min	28*
According to customer requirement ,we can adjust MFI.				
Mechanical				
Tensile Strength at break	50mm/min	ISO 527	MPa	32
Tensile Elongation	50mm/min	ISO 527	%	42
Rockwell Hardness	R-Scale	ASTM D785		105
Charpy Impact Strength (Notched)		ISO 179	KJ/M ²	9.2
Thermal				
Heat Deflection Temperature	18.6kg	ASTM D648	°C	78
Vicat Softening Temperature	5kg, 50°C/h	ASTM D1525	°C	95
Flammability	1.6mm	UL94	class	HB

Processing Guide (Extrusion Molding)

Processing Parameters		Unit	Value
Drying Temperature		° C	80 ~ 90
Drying Time		hrs	2 ~ 3
Minimum Moisture Content		%	0.01
Melt Temperature		° C	200 ~ 230
Barrel Temperature	Zone 1	° C	190 ~ 200
	Zone 2	° C	200 ~ 220
	Zone 3	° C	210 ~ 230
	Zone 4	° C	210 ~ 230
Adapter Temperature		° C	210 ~ 230
Die Temperature		° C	210 ~ 250
Roll Stack Temperature	Top	° C	70 ~ 90
	Middle	° C	70 ~ 90
	Bottom	° C	70 ~ 100

Note: Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.





Plastic & polymer additives and solution supplier

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Package:

25kg woven bag or paper bag or according to customer's requirement.

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