

# **DATA SHEET**

Acrylonitrile styrene acrylate (ASA), also called acrylic styrene acrylonitrile, is an amorphous thermoplastic developed as an alternative to acrylonitrile butadiene styrene (ABS), but with improved weather resistance, and is widely used in the automotive industry. It is an acrylate rubbermodified styrene acrylonitrile copolymer. It is used for general prototyping in 3D printing, where its UV resistance and mechanical properties make it an excellent material for use in fused deposition modelling printers.

## Material properties

Description	Method	Typical value
Density	ASTM D792	1.07 g/cm <sup>3</sup>
Melt Flow Index	ASTM D1238 (220°C/10 kg)	6 g/10 min
Heat deflection temperature	ASTM D648 (4.6 kg)	96°C
Heat deflection temperature	ASTM D648 (18.6 kg)	86°C
Vicat softening temperature	ASTM D1525 (5kg, 50°C/h)	94°C
Tensile strenght (3.2mm/yield)	ASTM D638 (50mm/min)	40 Mpa
Tensile modulus (3.2mm)	ASTM D638 (1mm/min)	1726 Mpa
Tensile elongation (3.2 mm/break)	ASTM D638 (50mm/min)	35 %
Tensile elongation (3.2 mm/yield)	ASTM D638 (50mm/min)	5 %
Rockwell hardness	ASTM D784 (R-Scale)	93

### Printing properties

Hotend temperature	255 -265°C
Heatbed temperature	105 - 115°C
Cooling print object	0 - 30%
Nozzle diameter	commonly used
Printing environment	inside of box recommended
Bed surface	commonly used (glassbed, PEI, steel etc)
Bed adhesive	glue stick for easy removal, 3Dlac

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2 - 3 hours at 80°C Drying material

#### Weight of empty spool Type of spool

750 gr	transparent	230gr
1 kg	transparent	250gr
1 kg	black	220gr
2,5kg	black	500gr

AURAPOL s.r.o. Šumná 125, 67102 Šumná IČ: 09318356, Vedená u Krajského soudu v Brně, C 118420 tel: +420 511 110 077 www.aurapol.com

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