

Technical Data Sheet



Centrex 485CS

Acrylonitrile Styrene Acrylate
LyondellBasell Industries
Engineering Plastics

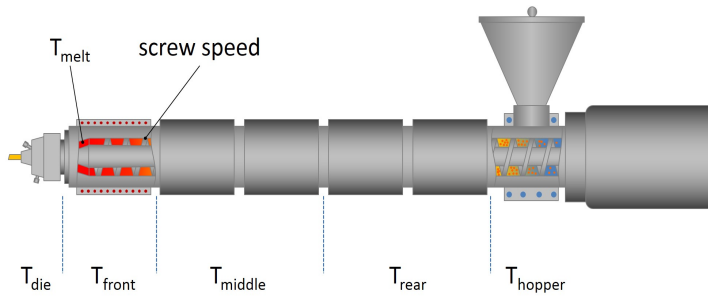
General			
Material Status	• Commercial: Active		
Availability	• North America		
Features	• Good Melt Strength • Good Weather Resistance	• Low Gloss • Medium Impact Resistance	• UV Resistant
Uses	• Automotive Applications • Automotive Exterior Parts	• Automotive Exterior Trim • Automotive Interior Parts	• Outdoor Applications
UL File NumberUSA	• E150937		
Forms	• Pellets		
Processing Method	• Coextrusion	• Extrusion	• Thermoforming
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity			
--	1.06	1.06 g/cm ³	ASTM D792
73°F (23°C)	1.07 g/cm ³	1.07 g/cm ³	ISO 1183/A
Melt Mass-Flow Rate (MFR)			
220°C/10.0 kg	5.0 g/10 min	5.0 g/10 min	ASTM D1238
220°C/10.0 kg	6.1 g/10 min	6.1 g/10 min	ISO 1133
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus ¹	210000 psi	1450 MPa	ASTM D638
Tensile Strength ¹ (Yield)	3850 psi	26.5 MPa	ASTM D638
Flexural Modulus - Tangent ²	200000 psi	1380 MPa	ASTM D790
Flexural Strength ²	5600 psi	38.6 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
-40°F (-40°C), 0.125 in (3.18 mm)	0.80 ft·lb/in	43 J/m	
0°F (-18°C), 0.125 in (3.18 mm)	1.2 ft·lb/in	64 J/m	
73°F (23°C), 0.125 in (3.18 mm)	2.4 ft·lb/in	130 J/m	
Instrumented Dart Impact			ASTM D3763
-22°F (-30°C), Total Energy	53.1 in·lb	6.00 J	
0°F (-18°C), Total Energy	142 in·lb	16.0 J	
73°F (23°C), Total Energy	212 in·lb	24.0 J	
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-Scale)	69	69	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.125 in (3.18 mm)	155 °F	68.3 °C	
Vicat Softening Temperature	212 °F	100 °C	ASTM D1525
CLTE - Flow	5.2E-5 in/in/°F	9.4E-5 cm/cm/°C	ASTM D696
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 in (1.5 mm))	HB	HB	UL 94
Optical	Nominal Value (English)	Nominal Value (SI)	Test Method
Gloss			ASTM D523
60° ³	20	20	
60° ⁴	10	10	

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Extrusion	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	180 to 200 °F	82 to 93 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	< 0.03 %	< 0.03 %
Suggested Max Regrind	40 %	40 %
Melt Temperature	400 to 470 °F	204 to 243 °C
Die Temperature	410 to 465 °F	210 to 241 °C

Extrusion Notes

Polish roll Top: Down stack 200°F, Up stack 200°F
Polish roll Middle: Down stack 165°F, Up stack 190°F
Polish roll Bottom: Down stack 200°F, Up stack 180°F

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Notes

¹ 0.20 in/min (5.1 mm/min)

² 0.050 in/min (1.3 mm/min)

³ Sheet

⁴ Formed

Notes

These are typical property values not to be construed as specification limits.

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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