

TECHNICAL DATA SHEET

# STAREX SD-0150

Lotte Chemical Corporation

ABS

**Processing**

Injection molding

**Delivery Form**

Pellets, Natural color

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	2	g/10min	ISO 1133
Temperature	200	°C	
Load	5	kg	
Melt flow index, MFI	2	g/10min	ASTM D 1238
Temperature	200	°C	
Load	5	kg	
Mechanical Properties	Value	Unit	Standard
Yield stress	51	MPa	ISO 527
Poisson's ratio	0.35		ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Flexural strength	76	MPa	ISO 178
Charpy notched impact strength, +23°C	24	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	21	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 109		ISO 2039-2
Tensile modulus	2200	MPa	ASTM D 638
Tensile strength at yield	41	MPa	ASTM D 638
Tensile strength at break	41	MPa	ASTM D 638
Elongation at break	39	%	ASTM D 638
Flexural modulus	2100	MPa	ASTM D 790
Flexural strength	62	MPa	ASTM D 790
Rockwell hardness	R 109		ASTM D 785
Izod impact notched, 1/8 in	340	J/m	ASTM D 256
Izod impact notched, 1/4 in	220	J/m	ASTM D 256

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Thermal Properties	Value	Unit	Standard
Vicat softening temperature, B	99	°C	ISO 306
DTUL @ 264 psi	84	°C	ASTM D 648
Other Properties	Value	Unit	Standard
Density	1040	kg/m <sup>3</sup>	ISO 1183
Density	1040	kg/m <sup>3</sup>	ASTM D 792
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	80	°C	
Pre-drying - time	2 - 4	h	
Processing humidity	≤0.05	%	
Melt temperature	230	°C	
Mold temperature	40 - 80	°C	
Zone 1	160 - 180	°C	
Zone 2	190 - 200	°C	
Zone 3	210 - 220	°C	
Nozzle temperature	230	°C	
Screw speed	50 - 150	rpm	
Injection pressure	49 - 150	MPa	
Back pressure	0.5 - 2	MPa	