

## TECHNICAL DATA SHEET

# STAREX SR-0320 K

Lotte Chemical Corporation  
 ABS

**Processing**

Injection molding

Pellets, Natural color

**Applications**

Automotive, Electrical and electronical

**Delivery Form**

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	9	g/10min	ISO 1133
Temperature	220	°C	
Load	10	kg	
Molding shrinkage, parallel	0.55	%	ISO 294-4, 2577
Molding shrinkage, normal	0.55	%	ISO 294-4, 2577
Melt flow index, MFI	9	g/10min	ASTM D 1238
Temperature	220	°C	
Load	10	kg	
Mold shrinkage, MD	0.0055	mm/mm	ASTM D 955
Mold shrinkage, TD	0.0055	mm/mm	ASTM D 955
Mechanical Properties	Value	Unit	Standard
Yield stress	48	MPa	ISO 527
Strain at break	36	%	ISO 527
Flexural modulus, 23°C	2450	MPa	ISO 178
Flexural strength	76	MPa	ISO 178
Charpy notched impact strength, +23°C	15	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	17	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 110		ISO 2039-2
Tensile strength at yield	41	MPa	ASTM D 638
Elongation at break	35	%	ASTM D 638
Flexural modulus	2200	MPa	ASTM D 790
Flexural strength	64	MPa	ASTM D 790
Rockwell hardness	R 110		ASTM D 785

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Mechanical Properties	Value	Unit	Standard
Izod impact notched, 1/4 in	170	J/m	ASTM D 256
<b>Thermal Properties</b>			
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	86	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	100	°C	ISO 75-1/-2
Vicat softening temperature, B	106	°C	ISO 306
UL 94 flame rating	HB		UL 94
Thickness tested	1.5	mm	
DTUL @ 264 psi	94	°C	ASTM D 648
<b>Other Properties</b>			
Other Properties	Value	Unit	Standard
Water absorption	0.3	%	Sim. to ISO 62
Density	1060	kg/m <sup>3</sup>	ISO 1183
Density	1060	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	90	°C	
Pre-drying - time	3 - 4	h	
Processing humidity	≤0.1	%	
Melt temperature	220 - 230	°C	
Mold temperature	40 - 80	°C	
Zone 1	190 - 205	°C	
Zone 2	205 - 225	°C	
Zone 3	225 - 245	°C	
Nozzle temperature	230 - 260	°C	
Screw speed	50 - 150	rpm	
Injection pressure	49 - 150	MPa	
Back pressure	0.5 - 2	MPa	