

TECHNICAL DATA SHEET

STAREX SR-0325LT

Lotte Chemical Corporation
ABS

Processing

Injection molding

Delivery Form

Pellets, Natural color

Applications

Automotive

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	4	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	4	g/10min	ASTM D 1238
Temperature	220	°C	
Load	10	kg	
Mold shrinkage, MD	0.005	mm/mm	ASTM D 955
Mold shrinkage, TD	0.006	mm/mm	ASTM D 955
Mechanical Properties	Value	Unit	Standard
Tensile modulus	2500	MPa	ISO 527
Yield stress	50	MPa	ISO 527
Stress at break	50	MPa	ISO 527
Strain at break	20	%	ISO 527
Poisson's ratio	0.35		ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Flexural strength	85	MPa	ISO 178
Charpy notched impact strength, +23°C	15	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	15	kJ/m ²	ISO 180/1A
Izod notched impact strength	7	kJ/m ²	ISO 180/1A
Temperature	-30	°C	
Rockwell hardness	R 113		ISO 2039-2

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Mechanical Properties	Value	Unit	Standard
Tensile modulus	2100	MPa	ASTM D 638
Tensile strength at yield	43	MPa	ASTM D 638
Tensile strength at break	43	MPa	ASTM D 638
Elongation at break	20	%	ASTM D 638
Flexural modulus	2100	MPa	ASTM D 790
Flexural strength	61	MPa	ASTM D 790
Rockwell hardness	R 113		ASTM D 785
Izod impact notched, 1/8 in	150	J/m	ASTM D 256
Izod impact notched, 1/4 in	120	J/m	ASTM D 256
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	92	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	105	°C	ISO 75-1/-2
Vicat softening temperature, B	113	°C	ISO 306
DTUL @ 66 psi	110	°C	ASTM D 648
DTUL @ 264 psi	100	°C	ASTM D 648
Other Properties	Value	Unit	Standard
Density	1060	kg/m ³	ISO 1183
Density	1060	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	90	°C	
Pre-drying - time	3 - 4	h	
Processing humidity	≤0.1	%	
Melt temperature	230 - 260	°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	