

TECHNICAL DATA SHEET

STAREX WR-9330I

Lotte Chemical Corporation
 ASA

Processing

Injection molding

Delivery Form

Pellets, Natural color

Special Characteristics

U.V. stabilized or stable to weather

Applications

Automotive

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	5	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	5	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
Tensile modulus	2400	MPa	ISO 527
Yield stress	52	MPa	ISO 527
Strain at break	11	%	ISO 527
Poisson's ratio	0.35		ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	9	kJ/m ²	ISO 180/1A
Rockwell hardness	R 108		ISO 2039-2
Tensile modulus	2100	MPa	ASTM D 638
Tensile strength at yield	47	MPa	ASTM D 638

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Mechanical Properties	Value	Unit	Standard
Elongation at break	17	%	ASTM D 638
Flexural modulus	2300	MPa	ASTM D 790
Flexural strength	70	MPa	ASTM D 790
Rockwell hardness	R 107		ASTM D 785
Izod impact notched, 1/8 in	140	J/m	ASTM D 256
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	82	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	97	°C	ISO 75-1/-2
Vicat softening temperature, B	104	°C	ISO 306
Other Properties	Value	Unit	Standard
Density	1070	kg/m ³	ISO 1183
Density	1070	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	75 - 85	°C	
Pre-drying - time	2 - 4	h	
Processing humidity	≤0.05	%	
Melt temperature	230 - 260	°C	
Mold temperature	50 - 70	°C	
Zone 1	190 - 205	°C	
Zone 2	205 - 225	°C	
Zone 3	225 - 245	°C	
Nozzle temperature	245	°C	
Screw speed	50 - 90	rpm	
Injection pressure	98	MPa	
Back pressure	1 - 2	MPa	