

TECHNICAL DATA SHEET

# STAREX WR-9300HF

Lotte Chemical Corporation  
ASA

**Processing**

Injection molding

**Delivery Form**

Pellets, Natural color

**Applications**

Automotive

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	12	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	12	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	44	MPa	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	67	MPa	ISO 178
Charpy notched impact strength, +23°C	13	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	12	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	5.5	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	
Rockwell hardness	R 106		ISO 2039-2
Tensile strength at yield	44	MPa	ASTM D 638
Elongation at break	15	%	ASTM D 638
Flexural modulus	2200	MPa	ASTM D 790
Flexural strength	67	MPa	ASTM D 790

# STAREX WR-9300HF

Lotte Chemical Corporation

Mechanical Properties	Value	Unit	Standard
Rockwell hardness	R 106		ASTM D 785
Izod impact notched, 1/8 in	150	J/m	ASTM D 256
Izod impact notched, 1/4 in	98	J/m	ASTM D 256
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	80	°C	ISO 75-1/-2
Vicat softening temperature, B	100	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	
UL 94 flame rating	HB		UL 94
Thickness tested	1.5	mm	
DTUL @ 66 psi	86	°C	ASTM D 648
DTUL @ 264 psi	73	°C	ASTM D 648
Other Properties	Value	Unit	Standard
Density	1070	kg/m <sup>3</sup>	ISO 1183
Density	1070	kg/m <sup>3</sup>	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	220 - 245	°C	
Nozzle temperature	245	°C	
Screw speed	50 - 90	rpm	
Injection pressure	49 - 250	MPa	
Back pressure	0.5 - 2	MPa	