Starex HF-0660M

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General

Uses	• Appliances

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.04		ASTM D792
Density (Natural)	1.04	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.0	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 4.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	3.0E-3 to 4.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.30 to 0.40	%	
Flow : 0.0787 in	0.30 to 0.40	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus [2]	310000	psi	ASTM D638
Tensile Modulus	290000	psi	ISO 527-1/50
Tensile Strength [2] (Yield)	5830	psi	ASTM D638
Tensile Stress (Yield)	6670	psi	ISO 527-2/50
Tensile Strength [2] (Break)	4980	psi	ASTM D638
Tensile Stress (Break)	5080	psi	ISO 527-2/50
Tensile Elongation [2] (Break)	20	%	ASTM D638
Tensile Strain (Break)	10	%	ISO 527-2/50
Flexural Modulus [3]	327000	psi	ASTM D790
Flexural Modulus [4]	363000	psi	ISO 178
Flexural Strength [3]	9250	psi	ASTM D790
Flexural Stress [4]	10300	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	10	ft·lb/in²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	3.9	ft·lb/in	
73°F, 0.250 in	3.1	ft·lb/in	
Notched Izod Impact Strength [5] (73°F)	9.5	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	108		ASTM D785
Rockwell Hardness (R-Scale)	109		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	194	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	194	°F	

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	187	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	172	°F	
Vicat Softening Temperature	207	°F	ISO 306/B50

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176	°F
Hot Air Dryer	176	°F
Drying Time		
Desiccant Dryer	2.0 to 3.0	hr
Hot Air Dryer	2.0 to 4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	320 to 356	°F
Middle Temperature	374 to 392	°F
Front Temperature	410 to 428	°F
Nozzle Temperature	446	°F
Mold Temperature	104 to 176	°F
Injection Pressure	7110 to 21300	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 230°C