

Starex EU-0191S

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General

Uses • Appliances

Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.04		ASTM D792
Density (Natural)	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	2.5	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	2.5	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 6.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	4.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	341000	psi	ASTM D638
Tensile Modulus	406000	psi	ISO 527-1/50
Tensile Strength ² (Yield)	7250	psi	ASTM D638
Tensile Stress (Yield)	7540	psi	ISO 527-2/50
Tensile Strength ² (Break)	6540	psi	ASTM D638
Tensile Stress (Break)	6380	psi	ISO 527-2/50
Flexural Modulus ³	348000	psi	ASTM D790
Flexural Modulus ⁴	348000	psi	ISO 178
Flexural Strength ³	10200	psi	ASTM D790
Flexural Stress ⁴	11300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	20	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	7.3	ft·lb/in	
73°F, 0.250 in	5.3	ft·lb/in	
Notched Izod Impact Strength ⁵ (73°F)	19	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	107		ASTM D785
Rockwell Hardness (R-Scale)	107		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in	210	°F	ASTM D648
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	207	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	198	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	185	°F	ISO 75-2/A
Vicat Softening Temperature	216	°F	ISO 306/B50

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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