Starex CM-0140UV

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

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)	3.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.0	g/10 min	ISO 1133
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2] (Yield)	6120	psi	ASTM D638
Tensile Stress (Yield)	6530	psi	ISO 527-2/50
Flexural Modulus [3]	299000	psi	ASTM D790
Flexural Modulus [4]	290000	psi	ISO 178
Flexural Strength [3]	9100	psi	ASTM D790
Flexural Stress [4]	9430	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	9.5	ft·lb/in²	ISO 179/1eA
Notched Izod Impact (73°F, 0.250 in)	3.7	ft·lb/in	ASTM D256
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)	109		ASTM D785
Rockwell Hardness (R-Scale)	109		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	167	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	169	°F	
Vicat Softening Temperature	203	°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	0.10	%
Rear Temperature	374 to 410	°F
Middle Temperature	410	°F
Front Temperature	410 to 428	°F
Nozzle Temperature	446	°F

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Injection	Nominal Value	Unit
Mold Temperature	104 to 176	°F
Injection Pressure	12800	psi
Back Pressure	142 to 284	psi
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 230°C