

Starex EG-0780

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General

Uses • Appliances

Properties ¹

Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	11	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	11	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	5120	psi	ASTM D638
Tensile Stress (Break)	4350	psi	ISO 527-2/5
Flexural Modulus ³	256000	psi	ASTM D790
Flexural Modulus ⁴	363000	psi	ISO 178
Flexural Strength ³	7540	psi	ASTM D790
Flexural Stress ⁴	5800	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	12	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact (73°F, 0.250 in)	6.4	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95		ASTM D785
Rockwell Hardness (R-Scale)	94		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
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	3.0 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