

# Starex EG-0191F

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

## General Information

### General

Uses • Appliances

## Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.04		ASTM D792
Density (Natural)	1.04	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	15	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	15	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
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.30 to 0.60	%	
Flow : 0.0787 in	0.30 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	6260	psi	ASTM D638
Tensile Stress (Yield)	5080	psi	ISO 527-2/5
Flexural Modulus <sup>3</sup>	327000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	290000	psi	ISO 178
Flexural Strength <sup>3</sup>	8960	psi	ASTM D790
Flexural Stress <sup>4</sup>	7250	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	14	ft-lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.250 in)	4.4	ft-lb/in	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (73°F)	13	ft-lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	98		ASTM D785
Rockwell Hardness (R-Scale)	98		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	208	°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

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Injection	Nominal Value	Unit
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