Starex MP-0660

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General	
RoHS Compliance	• RoHS Compliant
Forms	• Pellets

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)	3.5	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.5	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 Modulus	348000	psi	ISO 527-1/50
Tensile Strength [2] (Yield)	5690	psi	ASTM D638
Tensile Stress (Yield)	6820	psi	ISO 527-2/50
Tensile Stress (Break)	5080	psi	ISO 527-2/2
Tensile Strain (Break)	18	%	ISO 527-2/50
Flexural Modulus [3]	313000	psi	ASTM D790
Flexural Modulus [4]	363000	psi	ISO 178
Flexural Strength [3]	8530	psi	ASTM D790
Flexural Stress [4]	11000	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)	112		ASTM D785
Rockwell Hardness (R-Scale)	112		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	190	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Annealed, 0.157 in	208	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	167	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Annealed, 0.157 in	201	°F	

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Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature			
--	208	°F	ISO 306/B120
--	203	°F	ISO 306/B50

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	185 to 203	°F
Hot Air Dryer	185 to 203	°F
Drying Time		
Desiccant Dryer	2.0 to 4.0	hr
Hot Air Dryer	2.0 to 4.0	hr
Suggested Max Moisture	< 0.10	%
Rear Temperature	356 to 410	°F
Middle Temperature	392 to 410	°F
Front Temperature	410 to 446	°F
Nozzle Temperature	428 to 464	°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: 210 to 230 °C