Starex MR-0130

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General	
Uses	• Medical Devices
Forms	• Pellets

Properties [1]

Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	40	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	40	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 [2] (Yield)	5830	psi	ASTM D638
Tensile Stress (Yield)	5080	psi	ISO 527-2/5
Flexural Modulus [3]	313000	psi	ASTM D790
Flexural Modulus [4]	305000	psi	ISO 178
Flexural Strength [3]	8960	psi	ASTM D790
Flexural Stress [4]	7250	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	4.8	ft·lb/in²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	3.9	ft·lb/in	
73°F, 0.250 in	3.3	ft·lb/in	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	109		ASTM D785
Rockwell Hardness (R-Scale)	108		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Vicat Softening Temperature	• 201 • 199	°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 4.0	hr
Hot Air Dryer	2.0 to 3.0	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