

Starex LX-0981M

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General

Uses • Appliances

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.06		ASTM D792
Density (Natural)	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.0	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 ²	319000	psi	ASTM D638
Tensile Strength ² (Yield)	6380	psi	ASTM D638
Tensile Stress (Yield)	7250	psi	ISO 527-2/50
Flexural Modulus ³	299000	psi	ASTM D790
Flexural Modulus ⁴	305000	psi	ISO 178
Flexural Strength ³	8820	psi	ASTM D790
Flexural Stress ⁴	10200	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	6.2	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	2.8	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	109		ASTM D785
Rockwell Hardness (R-Scale)	111		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in	192	°F	ASTM D648
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	174	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	180	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	163	°F	ISO 75-2/A

Starex LX-0981M

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

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	392 to 428	°F
Middle Temperature	428 to 446	°F
Front Temperature	446 to 464	°F
Nozzle Temperature	482	°F
Mold Temperature	104 to 176	°F
Injection Pressure	14200	psi
Back Pressure	142 to 284	psi
Screw Speed	50 to 90	rpm

Injection Notes

Hot Runner Temperature: 250°C