

Starex LX-0760

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General

Uses • Appliances

Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.04		ASTM D792
Density (Natural)	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.2	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.2	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	334000	psi	ASTM D638
Tensile Strength ² (Yield)	5950	psi	ASTM D638
Tensile Stress (Yield)	6530	psi	ISO 527-2/50
Tensile Strength ² (Break)	4930	psi	ASTM D638
Flexural Modulus ³	305000	psi	ASTM D790
Flexural Modulus ⁴	348000	psi	ISO 178
Flexural Strength ³	8700	psi	ASTM D790
Flexural Stress ⁴	10400	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	9.0	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	2.6	ft-lb/in	
73°F, 0.250 in	2.6	ft-lb/in	
Notched Izod Impact Strength ⁵ (73°F)	8.1	ft-lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	107		ASTM D785
Rockwell Hardness (R-Scale)	107		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	201	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	185	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	171	°F	
Vicat Softening Temperature	205	°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

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Injection	Nominal Value	Unit
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 392	°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: 230 to 210°C