

Starex PT-0180B

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

Properties ¹			
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) (220°C/10.0 kg)	33	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	33	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.40 to 0.70	%	
Flow : 0.0787 in	0.40 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	299000	psi	ASTM D638
Tensile Modulus	305000	psi	ISO 527-1/50
Tensile Strength ² (Yield)	6120	psi	ASTM D638
Tensile Stress (Yield)	5800	psi	ISO 527-2/50
Tensile Strength ² (Break)	5830	psi	ASTM D638
Tensile Stress (Break)	5080	psi	ISO 527-2/50
Tensile Elongation ² (Break)	25	%	ASTM D638
Tensile Strain (Break)	25	%	ISO 527-2/50
Flexural Modulus ³	299000	psi	ASTM D790
Flexural Modulus ⁴	319000	psi	ISO 178
Flexural Strength ³	8960	psi	ASTM D790
Flexural Stress ⁴	8700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	16	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	6.4	ft·lb/in	
73°F, 0.250 in	6.1	ft·lb/in	
Notched Izod Impact Strength ⁵ (73°F)	16	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	102		ASTM D785
Rockwell Hardness (R-Scale)	102		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	207	°F	ISO 306/B50

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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	3.0	hr
Hot Air Dryer	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	711 to 2130	psi
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 210 to 230°C