

# Starex PT-0180 H

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

## General Information

### General

Uses • Automotive Applications

## Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.04		ASTM D792
Density (Natural)	1.04	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	2.3	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	2.3	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
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	5400	psi	ASTM D638
Tensile Stress (Yield)	6090	psi	ISO 527-2/50
Flexural Modulus <sup>3</sup>	290000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	305000	psi	ISO 178
Flexural Strength <sup>3</sup>	8530	psi	ASTM D790
Flexural Stress <sup>4</sup>	9570	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	15	ft-lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.250 in)	6.1	ft-lb/in	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (73°F)	15	ft-lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Rockwell Hardness (R-Scale)	105		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	183	°F	ASTM D648
Vicat Softening Temperature	207	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		HB	
0.12 in		HB	

## 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 3.0	hr
Hot Air Dryer	3.0 to 4.0	hr

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Injection	Nominal Value	Unit
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: 210 to 230 °C