

# Starex SR-0325L

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)	1.06		ASTM D792
Density (Natural)	1.06	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	8.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	8.0	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	%	
Water Absorption (Saturation, 73°F)	< 0.10	%	ASTM D570
Water Absorption (Saturation, 73°F)	< 0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus <sup>2</sup>	348000	psi	ASTM D638
Tensile Modulus	348000	psi	ISO 527-1/50
Tensile Strength <sup>2</sup> (Yield)	7110	psi	ASTM D638
Tensile Stress (Yield)	6960	psi	ISO 527-2/50
Tensile Strength <sup>2</sup> (Break)	6680	psi	ASTM D638
Tensile Stress (Break)	6240	psi	ISO 527-2/50
Tensile Elongation <sup>2</sup> (Break)	20	%	ASTM D638
Tensile Strain (Break)	20	%	ISO 527-2/50
Flexural Modulus <sup>3</sup>	348000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	348000	psi	ISO 178
Flexural Strength <sup>3</sup>	10700	psi	ASTM D790
Flexural Stress <sup>4</sup>	10900	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	6.2	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	2.8	ft·lb/in	
73°F, 0.250 in	2.2	ft·lb/in	
Notched Izod Impact Strength <sup>5</sup> (73°F)	6.2	ft·lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Rockwell Hardness (R-Scale)	115		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	217	°F	

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### Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	199	°F	ISO 75-2/A
Vicat Softening Temperature	239	°F	ISO 306/B50

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176 to 194	°F
Hot Air Dryer	176 to 194	°F
Drying Time		
Desiccant Dryer	3.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	< 0.10	%
Rear Temperature	374 to 428	°F
Middle Temperature	410 to 446	°F
Front Temperature	446 to 500	°F
Nozzle Temperature	446 to 500	°F
Mold Temperature	122 to 176	°F
Injection Pressure	1420	psi
Back Pressure	711 to 2130	psi
Screw Speed	5 to 20	rpm

#### Injection Notes

Hot Runner Temperature: 230 to 260°C