

Starex SH-0160

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General

Uses • Industrial Applications • Sheet

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) (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)	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 Strength ² (Yield)	5120	psi	ASTM D638	
Tensile Stress (Yield)	5080	psi	ISO 527-2/50	
Flexural Modulus ³	261000	psi	ASTM D790	
Flexural Modulus ²	261000	psi	ISO 178	
Flexural Strength ³	7820	psi	ASTM D790	
Flexural Stress ²	7980	psi	ISO 178	
Impact	Nominal Value	Unit	Test Method	
Charpy Notched Impact Strength ⁴ (73°F)	13	ft·lb/in ²	ISO 179/1eA	
Notched Izod Impact			ASTM D256	
73°F, 0.125 in	8.2	ft·lb/in		
73°F, 0.250 in	6.0	ft·lb/in		
Hardness	Nominal Value	Unit	Test Method	
Rockwell Hardness (R-Scale)	101		ASTM D785	
Rockwell Hardness (R-Scale)	101		ISO 2039-2	
Thermal	Nominal Value	Unit	Test Method	
Deflection Temperature Under Load			ASTM D648	
264 psi, Unannealed, 0.252 in	194	°F		
Vicat Softening Temperature	• •	208 210	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method	
Flame Rating (0.06 to 0.12 in)	HB		UL 94	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176	°F
Hot Air Dryer	176	°F

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Injection	Nominal Value	Unit
Drying Time		
Desiccant Dryer	2.0 to 3.0	hr
Hot Air Dryer	2.0 to 4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	320 to 356	°F
Middle Temperature	374 to 392	°F
Front Temperature	410 to 428	°F
Nozzle Temperature	446	°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°C