Starex HG-0760TV

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General

Uses	• Electrical/Electronic Applications

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.04		ASTM D792
Density (Natural)	1.04	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.5	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.7	g/10 min	ISO 1133
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	334000	psi	ISO 527-1/50
Tensile Strength [2] (Yield)	5970	psi	ASTM D638
Tensile Stress (Yield)	6090	psi	ISO 527-2/50
Tensile Stress (Break)	4790	psi	ISO 527-2/50
Tensile Strain (Break)	14	%	ISO 527-2/50
Flexural Modulus [3]	319000	psi	ASTM D790
Flexural Modulus [4]	319000	psi	ISO 178
Flexural Strength [3]	8820	psi	ASTM D790
Flexural Stress [4]	8990	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	7.6	ft·lb/in²	ISO 179/1eA
Notched Izod Impact (73°F, 0.250 in)	3.0	ft·lb/in	ASTM D256
Notched Izod Impact Strength [5] (73°F)	7.1	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	110		ASTM D785
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	190	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Annealed, 0.157 in	212	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	167	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Annealed, 0.157 in	203	°F	
Vicat Softening Temperature	207	°F	ISO 306/B50
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94

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