

Starex SD-0150

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General

Uses	<ul style="list-style-type: none"> • Appliances • Automotive Applications
RoHS Compliance	<ul style="list-style-type: none"> • RoHS Compliant

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) (200°C/5.0 kg)	2.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	2.0	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	319000	psi	ASTM D638
Tensile Strength ³ (Yield)	5970	psi	ASTM D638
Tensile Stress (Yield)	7400	psi	ISO 527-2/50
Tensile Strength ² (Break)	5970	psi	ASTM D638
Tensile Elongation ² (Break)	39	%	ASTM D638
Flexural Modulus ⁴	305000	psi	ASTM D790
Flexural Modulus ⁵	363000	psi	ISO 178
Flexural Strength ⁴	8960	psi	ASTM D790
Flexural Stress ⁵	11000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶ (73°F)	11	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	4.1	ft·lb/in	
Notched Izod Impact Strength ⁶ (73°F)	10	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	109		ASTM D785
Rockwell Hardness (R-Scale)	109		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	183	°F	
Vicat Softening Temperature	210	°F	ISO 306/B50

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