

Starex SU-0191LH

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General

Uses • Automotive Applications

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) (220°C/10.0 kg)	3.5	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	3.5	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 Modulus ²	327000	psi	ASTM D638
Tensile Modulus	319000	psi	ISO 527-1/5
Tensile Strength ² (Yield)	7110	psi	ASTM D638
Tensile Stress (Yield)	6820	psi	ISO 527-2/50
Tensile Stress (Break)	5510	psi	ISO 527-2/5
Flexural Modulus ³	348000	psi	ASTM D790
Flexural Modulus ⁴	334000	psi	ISO 178
Flexural Strength ³	10200	psi	ASTM D790
Flexural Stress ⁴	10400	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	15	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	5.9	ft-lb/in	
73°F, 0.250 in	5.5	ft-lb/in	
Notched Izod Impact Strength ⁵ (73°F)	14	ft-lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Rockwell Hardness (R-Scale)	108		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	203	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	205	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	192	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	183	°F	

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Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	216	°F	ISO 306/B50

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176	°F
Hot Air Dryer	176	°F
Drying Time		
Desiccant Dryer	2.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	374 to 428	°F
Middle Temperature	428 to 446	°F
Front Temperature	446 to 464	°F
Nozzle Temperature	446	°F
Mold Temperature	140 to 176	°F
Injection Pressure	1420 to 2840	psi
Back Pressure	569 to 1710	psi
Screw Speed	30 to 90	rpm

Injection Notes

Hot Runner Temperature: 210 to 230°C