Starex VE-0812

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General		
Uses	• Appliances	• Electrical/Electronic Applications
RoHS Compliance	• RoHS Compliant	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.16		ASTM D792
Density (Natural)	1.16	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.3	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.3	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]	232000	psi	ASTM D638
Tensile Modulus	305000	psi	ISO 527-1/50
Tensile Strength [2] (Yield)	5690	psi	ASTM D638
Tensile Stress (Yield)	6380	psi	ISO 527-2/50
Tensile Strength [2] (Break)	3560	psi	ASTM D638
Tensile Stress (Break)	4500	psi	ISO 527-2/50
Flexural Modulus [3]	276000	psi	ASTM D790
Flexural Modulus [4]	319000	psi	ISO 178
Flexural Strength [3]	7820	psi	ASTM D790
Flexural Stress [4]	9860	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	8.6	ft·lb/in²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	3.2	ft·lb/in	
73°F, 0.250 in	2.8	ft·lb/in	
Notched Izod Impact Strength [5] (73°F)	9.5	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	99		ASTM D785
Rockwell Hardness (R-Scale)	103		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	192	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	185	°F	

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	176	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	163	°F	
Vicat Softening Temperature	• 194 • 192	°F	ISO 306/B50

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.10 in	V-0		
0.12 in	V-0		

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	428	°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: 220°C

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 0.20 in/min

[3] 0.11 in/min

[4] 0.079 in/min

[5] 4mm