Starex VE-0860EX

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

General Information

General

Uses	• Automotive Applications	• Electrical/Electronic Applications

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.18		ASTM D792
Density (Natural)	1.18	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	16	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	16	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
Molding Shrinkage - Flow (0.0787 in)	0.30 to 0.60	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	319000	psi	ISO 527-1/50
Tensile Strength [2] (Yield)	6260	psi	ASTM D638
Tensile Stress (Yield)	6820	psi	ISO 527-2/50
Tensile Stress (Break)	5080	psi	ISO 527-2/50
Tensile Strain (Break)	8.0	%	ISO 527-2/50
Flexural Modulus [3]	305000	psi	ASTM D790
Flexural Modulus [4]	334000	psi	ISO 178
Flexural Strength [3]	8530	psi	ASTM D790
Flexural Stress [4]	10400	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	11	ft·lb/in²	ISO 179/1eA
Notched Izod Impact (73°F, 0.250 in)	3.7	ft·lb/in	ASTM D256
Notched Izod Impact Strength [5] (73°F)	12	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	98		ASTM D785
Rockwell Hardness (R-Scale)	98		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	194	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Annealed, 0.157 in	196	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	180	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	172	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Annealed, 0.157 in	183	°F	
Vicat Softening Temperature			
--	207	°F	ISO 306/B120
--	201	°F	ISO 306/B50

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Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.10 to 0.11 in	• V-0 • 5VB		

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