

Starex VB-0200

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.15		ASTM D792
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
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	4980	psi	ASTM D638
Flexural Modulus ³	242000	psi	ASTM D790
Flexural Strength ³	7110	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	3.7	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	90		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	176	°F	ASTM D648
Vicat Softening Temperature	190	°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 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

Notes

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

² 2.0 in/min

³ 0.11 in/min