

# Starex VE-0871

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

Properties <sup>1</sup>			
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.17		ASTM D792
Density (Natural)	1.17	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	4.0	g/10 min	
220°C/10.0 kg	40	g/10 min	
Melt Mass-Flow Rate (MFR)			ISO 1133
200°C/5.0 kg	4.0	g/10 min	
220°C/10.0 kg	40	g/10 min	
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 <sup>2</sup> (Yield)	6120	psi	ASTM D638
Tensile Stress (Yield)	6240	psi	ISO 527-2/50
Flexural Modulus <sup>3</sup>	313000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	319000	psi	ISO 178
Flexural Strength <sup>3</sup>	8530	psi	ASTM D790
Flexural Stress <sup>4</sup>	9430	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	9.0	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.250 in)	3.7	ft·lb/in	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (73°F)	8.1	ft·lb/in <sup>2</sup>	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	178	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	171	°F	
Vicat Softening Temperature	196	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		V-0	
0.08 in		5VB	
		5VA	
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	428	°F
Mold Temperature	104 to 176	°F
Injection Pressure	1420	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

#### Injection Notes

Hot Runner Temperature: 220°C

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 0.20 in/min

<sup>3</sup> 0.11 in/min

<sup>4</sup> 0.079 in/min

<sup>5</sup> 4mm