

# Starex SV-0155

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

## General Information

### General

Uses • Appliances

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.04		ASTM D792
Density (Natural)	1.04	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.5	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.5	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus <sup>2</sup>	313000	psi	ASTM D638
Tensile Modulus	334000	psi	ISO 527-1/50
Tensile Strength <sup>2</sup> (Yield)	6120	psi	ASTM D638
Tensile Stress (Yield)	6530	psi	ISO 527-2/50
Tensile Strength <sup>2</sup> (Break)	4980	psi	ASTM D638
Tensile Stress (Break)	5080	psi	ISO 527-2/50
Flexural Modulus <sup>3</sup>	327000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	348000	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)	14	ft-lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	5.5	ft-lb/in	
73°F, 0.250 in	4.6	ft-lb/in	
Notched Izod Impact Strength <sup>5</sup> (73°F)	14	ft-lb/in <sup>2</sup>	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			ISO 75-2/B
66 psi, Unannealed, 0.157 in	203	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Annealed, 0.157 in	194	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	192	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Annealed, 0.157 in	176	°F	
Vicat Softening Temperature	212	°F	ISO 306/B50

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#### 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	0.020	%
Rear Temperature	374 to 392	°F
Middle Temperature	392 to 410	°F
Front Temperature	410 to 428	°F
Nozzle Temperature	428	°F
Mold Temperature	140 to 176	°F
Injection Pressure	7110	psi
Back Pressure	427 to 1710	psi
Screw Speed	30 to 60	rpm

#### Injection Notes

Hot Runner Temperature: 210 to 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