

Starex GC-0730

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene + PET

Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.12		ASTM D792
Density (Natural)	1.12	g/cm ³	ISO 1183
Molding Shrinkage - Flow (0.126 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.60 to 0.80	%	
Flow : 0.0787 in	0.60 to 0.80	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	247000	psi	ASTM D638
Tensile Modulus	254000	psi	ISO 527-1/50
Tensile Strength ² (Yield)	5690	psi	ASTM D638
Tensile Stress (Yield)	5800	psi	ISO 527-2/50
Tensile Strength ² (Break)	4270	psi	ASTM D638
Tensile Stress (Break)	4350	psi	ISO 527-2/50
Tensile Elongation ² (Break)	13	%	ASTM D638
Tensile Strain (Break)	10	%	ISO 527-2/50
Flexural Modulus ³	247000	psi	ASTM D790
Flexural Modulus ⁴	247000	psi	ISO 178
Flexural Strength ³	7820	psi	ASTM D790
Flexural Stress ⁴	7980	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
73°F, 0.125 in	10	ft·lb/in	
73°F, 0.250 in	2.2	ft·lb/in	
Notched Izod Impact Strength ⁵ (73°F)	17	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	90		ASTM D785
Rockwell Hardness (R-Scale)	90		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	181	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	165	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	160	°F	
Vicat Softening Temperature	196	°F	ISO 306/B50

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Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		HB	
0.12 in		HB	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	212	°F
Hot Air Dryer	212	°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	410	°F
Middle Temperature	428 to 446	°F
Front Temperature	464 to 482	°F
Nozzle Temperature	482	°F
Mold Temperature	104 to 176	°F
Injection Pressure	7110 to 35600	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 250°C

Notes

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

² 2.0 in/min

³ 0.11 in/min

⁴ 0.079 in/min

⁵ 4mm