

Starex EG-7030

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene + PET

General Information

General			
Uses	• Appliance Components		
Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.11		ASTM D792
Density (Natural)	1.11	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	18	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	18	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	6610	psi	ASTM D638
Tensile Stress (Yield)	6670	psi	ISO 527-2/50
Flexural Modulus ³	276000	psi	ASTM D790
Flexural Modulus ⁴	276000	psi	ISO 178
Flexural Strength ³	8250	psi	ASTM D790
Flexural Stress ⁴	7980	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	12	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	6.2	ft·lb/in	ASTM D256
Notched Izod Impact Strength ⁵ (73°F)	13	ft·lb/in ²	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 264 psi, Unannealed, 0.252 in	176	°F	ASTM D648
Vicat Softening Temperature	201	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.12 in)	HB		UL 94
Optical	Nominal Value	Unit	Test Method
Yellowness Index 0.126 in	27	YI	ASTM D1925
0.157 in	27	YI	

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

Starex EG-7030

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene + PET

Injection	Nominal Value	Unit
Suggested Max Moisture	< 0.050	%
Rear Temperature	410 to 428	°F
Middle Temperature	446 to 464	°F
Front Temperature	482 to 500	°F
Nozzle Temperature	500	°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 to 260°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