

Starex WX-9700A

Lotte Chemical Corporation - Acrylonitrile Styrene Acrylate

General Information

General

Uses • Telecommunications

Properties ¹

Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	5.0	g/10 min	ISO 1133
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
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.30 to 0.60	%	
Flow : 0.0787 in	0.30 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	5690	psi	ASTM D638
Tensile Stress (Yield)	5800	psi	ISO 527-2/50
Flexural Modulus ³	270000	psi	ASTM D790
Flexural Modulus ⁴	305000	psi	ISO 178
Flexural Strength ³	8530	psi	ASTM D790
Flexural Stress ⁴	8700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	16	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	9.2	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95		ASTM D785
Rockwell Hardness (R-Scale)	95		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	205 207	°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	hr
Hot Air Dryer	2.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	374 to 392	°F
Middle Temperature	410 to 446	°F
Front Temperature	428 to 446	°F
Nozzle Temperature	446	°F

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Injection	Nominal Value	Unit
Mold Temperature	104 to 176	°F
Injection Pressure	7110 to 28400	psi
Back Pressure	725 to 7250	psi
Screw Speed	10 to 100	rpm

Injection Notes

Hot Runner Temperature: 230°C

Notes

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

² 0.20 in/min

³ 0.11 in/min

⁴ 0.079 in/min

⁵ 4mm