

Starex WX-9730L

Lotte Chemical Corporation - Acrylonitrile Styrene Acrylate

General Information

General			
Uses	• Construction Applications		
Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.06		ASTM D792
Density (Natural)	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	3.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	3.0	g/10 min	ISO 1133
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	200000	psi	ISO 527-1/50
Tensile Strength ² (Yield)	4550	psi	ASTM D638
Tensile Stress (Yield)	3920	psi	ISO 527-2/50
Tensile Strength ² (Break)	4210	psi	ASTM D638
Tensile Stress (Break)	3480	psi	ISO 527-2/50
Flexural Modulus ³	203000	psi	ASTM D790
Flexural Modulus ⁴	225000	psi	ISO 178
Flexural Strength ³	5950	psi	ASTM D790
Flexural Stress ⁴	6820	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	8.6	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	5.4	ft·lb/in	
73°F, 0.250 in	2.1	ft·lb/in	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	75		ASTM D785
Rockwell Hardness (R-Scale)	70		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	176	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	174	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	163	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	162	°F	

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Thermal		Nominal Value	Unit	Test Method
Vicat Softening Temperature	•	187	°F	ISO 306/B50
	•	181		

Processing Information

Injection		Nominal Value	Unit
Drying Temperature			
Desiccant Dryer		176	°F
Hot Air Dryer		176	°F
Drying Time			
Desiccant Dryer		2.0 to 4.0	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		446	°F
Mold Temperature		104 to 176	°F
Injection Pressure		7110 to 21300	psi
Back Pressure		71.1 to 284	psi
Screw Speed		50 to 150	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