Starex WX-9415

Lotte Chemical Corporation - Acrylonitrile Styrene Acrylate

Properties [1]			
Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity (Natural)	1.24		ASTM D792
Density (Natural)	1.24	g/cm³	ISO 1183
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)	2.0E-3 to 4.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	2.0E-3 to 4.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.20 to 0.40	%	
Flow : 0.0787 in	0.20 to 0.40	%	
Ash Content	15	%	ASTM D5630
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	783000	psi	ISO 527-1/5
Tensile Strength [2] (Yield)	12000	psi	ASTM D638
Tensile Stress (Yield)	12000	psi	ISO 527-2/5
Tensile Stress (Break)	11300	psi	ISO 527-2/5
Tensile Strain (Break)	2.0	%	ISO 527-2/5
Flexural Modulus [3]	870000	psi	ASTM D790
Flexural Modulus [4]	885000	psi	ISO 178
Flexural Strength [3]	14500	psi	ASTM D790
Flexural Stress [4]	14500	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	2.1	ft·lb/in²	ISO 179/1eA
Notched Izod Impact Strength [5] (73°F)	2.0	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	115		ASTM D785
Rockwell Hardness (R-Scale)	115		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	230	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	230	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	228	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	228	°F	
Vicat Softening Temperature	239	°F	ISO 306/B50
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.02 to 0.24 in)	HB		UL 94

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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	2.0	hr
Suggested Max Moisture	0.050 to 0.070	%
Rear Temperature	428	°F
Middle Temperature	428	°F
Front Temperature	446	°F
Nozzle Temperature	464	°F
Mold Temperature	140	°F
Injection Pressure	13500	psi
Back Pressure	71.1 to 427	psi
Screw Speed	50 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