Starex WX-9130

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/cm³	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
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2] (Yield)	5690	psi	ASTM D638
Tensile Stress (Yield)	6530	psi	ISO 527-2/50
Flexural Modulus [3]	270000	psi	ASTM D790
Flexural Modulus [4]	290000	psi	ISO 178
Flexural Strength [3]	7820	psi	ASTM D790
Flexural Stress [4]	9430	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	6.7	ft·lb/in²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	9.2	ft·lb/in	ASTM D256
Notched Izod Impact Strength [5] (73°F)	5.7	ft·lb/in²	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			ISO 75-2/A
264 psi, Unannealed, 0.157 in	171	°F	
Vicat Softening Temperature	203	°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	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	356 to 392	°F
Middle Temperature	410 to 437	°F
Front Temperature	446 to 464	°F
Nozzle Temperature	482	°F
Mold Temperature	104 to 176	°F

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Injection	Nominal Value	Unit
Injection Pressure	14200	psi
Back Pressure	142 to 284	psi
Screw Speed	30 to 80	rpm

Injection Notes
Hot Runner Temperature: 240 to 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