

# Starex WX-9308HF

Lotte Chemical Corporation - Acrylonitrile Styrene Acrylate

Properties <sup>1</sup>			
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.07		ASTM D792
Density (Natural)	1.07	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	12	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	12	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.40 to 0.70	%	
Flow : 0.0787 in	0.40 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	6400	psi	ASTM D638
Tensile Stress (Yield)	6530	psi	ISO 527-2/50
Tensile Elongation <sup>2</sup> (Break)	15	%	ASTM D638
Tensile Strain (Break)	15	%	ISO 527-2/50
Flexural Modulus <sup>3</sup>	313000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	334000	psi	ISO 178
Flexural Strength <sup>3</sup>	9670	psi	ASTM D790
Flexural Stress <sup>4</sup>	10900	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
73°F, 0.125 in	2.4	ft-lb/in	
73°F, 0.250 in	1.8	ft-lb/in	
Notched Izod Impact Strength <sup>5</sup> (73°F)	5.2	ft-lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	109		ASTM D785
Rockwell Hardness (R-Scale)	109		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	205	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	181	°F	
Vicat Softening Temperature	• •	219 217	°F ISO 306/B50

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### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	167 to 185	°F
Hot Air Dryer	167 to 185	°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	374 to 401	°F
Middle Temperature	401 to 437	°F
Front Temperature	437 to 473	°F
Nozzle Temperature	473	°F
Mold Temperature	122 to 158	°F
Injection Pressure	14200	psi
Back Pressure	142 to 284	psi
Screw Speed	50 to 90	rpm

### Injection Notes

Hot Runner Temperature: 230 to 260°C

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 2.0 in/min

<sup>3</sup> 0.11 in/min

<sup>4</sup> 0.079 in/min

<sup>5</sup> 4mm