Starex WX-9330UV

Lotte Chemical Corporation - Acrylonitrile Styrene Acrylate

General Information

General

Uses	• Automotive Applications

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.09		ASTM D792
Density (Natural)	1.09	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	4.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	4.0	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
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus [2]	290000	psi	ASTM D638
Tensile Strength [2] (Yield)	6400	psi	ASTM D638
Tensile Stress (Yield)	6530	psi	ISO 527-2/5
Tensile Strength [2] (Break)	5690	psi	ASTM D638
Tensile Elongation [2] (Break)	36	%	ASTM D638
Flexural Modulus [3]	305000	psi	ASTM D790
Flexural Modulus [4]	334000	psi	ISO 178
Flexural Strength [3]	9100	psi	ASTM D790
Flexural Stress [4]	10600	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	6.2	ft·lb/in²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	4.1	ft·lb/in	
73°F, 0.250 in	1.5	ft·lb/in	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	103		ASTM D785
Rockwell Hardness (R-Scale)	103		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	214	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	198	°F	
Vicat Softening Temperature	217	°F	ISO 306/B50

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	167 to 185	°F
Hot Air Dryer	167 to 185	°F

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Injection	Nominal Value	Unit
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

[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