Starex WR-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)	10	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	10	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage - Flow (0.0787 in)	0.40 to 0.70	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2] (Yield)	5550	psi	ASTM D638
Tensile Stress (Yield)	5800	psi	ISO 527-2/50
Tensile Elongation [2] (Break)	110	%	ASTM D638
Flexural Modulus [3]	256000	psi	ASTM D790
Flexural Modulus [4]	232000	psi	ISO 178
Flexural Strength [3]	8250	psi	ASTM D790
Flexural Stress [4]	8270	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	5.2	ft·lb/in²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	2.8	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	103		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	183	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	167	°F	
Vicat Softening Temperature	203	°F	ISO 306/B50
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176	°F
Hot Air Dryer	203	°F
Drying Time		
Desiccant Dryer	2.0 to 4.0	hr
Hot Air Dryer	2.0 to 4.0	hr
Suggested Max Moisture	< 0.10	%

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Injection	Nominal Value	Unit
Rear Temperature	410	°F
Middle Temperature	419	°F
Front Temperature	437	°F
Nozzle Temperature	455	°F
Mold Temperature	104 to 176	°F
Injection Pressure	12800	psi
Back Pressure	284 to 996	psi
Screw Speed	30 to 80	rpm

Injection Notes

Hot Runner Temperature: 220°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