

# Starex WR-9350

Lotte Chemical Corporation - Acrylonitrile Styrene Acrylate

## General Information

General			
Forms	• Pellets		

## Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	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)	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)	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 Modulus <sup>2</sup>	303000	psi	ASTM D638
Tensile Modulus	348000	psi	ISO 527-1/50
Tensile Strength <sup>2</sup> (Yield)	6830	psi	ASTM D638
Tensile Stress (Yield)	7540	psi	ISO 527-2/50
Tensile Elongation <sup>2</sup> (Break)	17	%	ASTM D638
Tensile Strain (Break)	11	%	ISO 527-2/50
Flexural Modulus <sup>3</sup>	327000	psi	ASTM D790
Flexural Modulus <sup>3</sup>	348000	psi	ISO 178
Flexural Strength <sup>3</sup>	10100	psi	ASTM D790
Flexural Stress <sup>3</sup>	11600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>4</sup> (73°F)	4.8	ft-lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	2.6	ft-lb/in	ASTM D256
Notched Izod Impact Strength <sup>4</sup> (73°F)	4.3	ft-lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	107		ASTM D785
Rockwell Hardness (R-Scale)	108		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	219	°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

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

<sup>2</sup> 0.20 in/min

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

<sup>4</sup> 4mm