

# Starex WX-9730LE

Lotte Chemical Corporation - Acrylonitrile Styrene Acrylate

## General Information

### General

Uses • Construction Applications

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.06		ASTM D792
Density (Natural)	1.06	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	3.5	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	3.5	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.60 to 0.80	%	
Flow : 0.0787 in	0.60 to 0.80	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus <sup>2</sup>	242000	psi	ASTM D638
Tensile Modulus	240000	psi	ISO 527-1/50
Tensile Strength <sup>2</sup> (Yield)	4690	psi	ASTM D638
Tensile Stress (Yield)	4060	psi	ISO 527-2/50
Tensile Strength <sup>2</sup> (Break)	4270	psi	ASTM D638
Tensile Stress (Break)	3770	psi	ISO 527-2/50
Flexural Modulus <sup>3</sup>	201000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	218000	psi	ISO 178
Flexural Strength <sup>3</sup>	5970	psi	ASTM D790
Flexural Stress <sup>4</sup>	6670	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	9.5	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	4.6	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	80		ASTM D785
Rockwell Hardness (R-Scale)	78		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	176	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	174	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	163	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	163	°F	
Vicat Softening Temperature			
	•	190	°F
	•	183	°F

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### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176	°F
Hot Air Dryer	176	°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	320 to 356	°F
Middle Temperature	374 to 392	°F
Front Temperature	410 to 428	°F
Nozzle Temperature	446	°F
Mold Temperature	104 to 176	°F
Injection Pressure	7110 to 21300	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

### Injection Notes

Hot Runner Temperature: 230°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> 0.079 in/min

<sup>5</sup> 4mm