

Starex TX-0550K

Lotte Chemical Corporation - Methyl Methacrylate / ABS

General Information

General			
Uses	• Appliances		
Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.08		ASTM D792
Density (Natural)	1.08	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	27	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	27	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 8.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	4.0E-3 to 8.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.40 to 0.80	%	
Flow : 0.0787 in	0.40 to 0.80	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	27000	psi	ASTM D638
Tensile Strength ² (Yield)	5690	psi	ASTM D638
Tensile Stress (Yield)	5800	psi	ISO 527-2/5
Tensile Strength ² (Break)	4980	psi	ASTM D638
Tensile Stress (Break)	5800	psi	ISO 527-2/5
Flexural Modulus ³	277000	psi	ASTM D790
Flexural Modulus ³	271000	psi	ISO 178
Flexural Strength ³	8530	psi	ASTM D790
Flexural Stress ³	8700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁴ (73°F)	7.1	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	3.3	ft·lb/in	
73°F, 0.250 in	3.1	ft·lb/in	
Notched Izod Impact Strength ⁴ (73°F)	8.1	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Rockwell Hardness (R-Scale)	106		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	178	°F	
Deflection Temperature Under Load ⁴			ISO 75-2/A
264 psi, Unannealed	163	°F	
Vicat Softening Temperature	194	°F	ISO 306/B50

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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	4.0 to 6.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	356 to 374	°F
Middle Temperature	392 to 410	°F
Front Temperature	428 to 446	°F
Nozzle Temperature	446	°F
Mold Temperature	122 to 158	°F
Injection Pressure	7110 to 28400	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	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 4mm