

Starex TX-0520

Lotte Chemical Corporation - Methyl Methacrylate / ABS

General Information

General	
Uses	• Appliances

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.10		ASTM D792
Density (Natural)	1.10	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	15	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	15	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)	6.0E-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 Strength ² (Yield)	6120	psi	ASTM D638
Tensile Stress (Yield)	6820	psi	ISO 527-2/50
Flexural Modulus ³	290000	psi	ASTM D790
Flexural Modulus ⁴	319000	psi	ISO 178
Flexural Strength ³	8530	psi	ASTM D790
Flexural Stress ⁴	10200	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	5.7	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	3.0	ft·lb/in	ASTM D256
Notched Izod Impact Strength ⁵ (73°F)	5.7	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	106		ASTM D785
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	189	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		HB	
0.12 in		HB	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176	°F
Hot Air Dryer	176	°F

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Drying Time		
Desiccant Dryer	2.0	hr
Hot Air Dryer	2.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	392 to 419	°F
Middle Temperature	419	°F
Front Temperature	419 to 446	°F
Nozzle Temperature	446	°F
Mold Temperature	104 to 140	°F
Injection Pressure	7110 to 28400	psi
Back Pressure	71.1 to 284	psi
Screw Speed	10 to 100	rpm

Injection Notes

Hot Runner Temperature: 230°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