

# Starex TX-0530T

Lotte Chemical Corporation - Methyl Methacrylate / ABS

## General Information

### General

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.10		ASTM D792
Density (Natural)	1.10	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	14	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	14	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	0.60 to 0.80	%	
Flow : 0.0787 in	0.40 to 0.80	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	5480	psi	ASTM D638
Tensile Stress (Yield)	6090	psi	ISO 527-2/50
Flexural Modulus <sup>3</sup>	262000	psi	ISO 178
Flexural Stress <sup>3</sup>	8850	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>4</sup> (73°F)	7.2	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	3.1	ft·lb/in	ASTM D256
Notched Izod Impact Strength <sup>4</sup> (73°F)	7.1	ft·lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	101		ASTM D785
Rockwell Hardness (R-Scale)	102		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	• •	189 187 °F	ISO 306/B50

## 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

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Injection	Nominal Value	Unit
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

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

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

<sup>3</sup> 0.079 in/min

<sup>4</sup> 4mm