

Starex BM-0320JM

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

Wednesday, March 9, 2022

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.04	g/cm ³	ASTM D792
Density (Natural)	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	6.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	6.0	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.30 to 0.60	%	ASTM D955
Molding Shrinkage - Across Flow (3.20 mm)	0.30 to 0.60	%	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	0.30 to 0.60	%	
Flow : 2.00 mm	0.30 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	46.0	MPa	ASTM D638
Tensile Stress (Yield)	44.0	MPa	ISO 527-2/50
Tensile Strength ² (Break)	43.0	MPa	ASTM D638
Tensile Elongation ² (Break)	15	%	ASTM D638
Tensile Strain (Break)	15	%	ISO 527-2/50
Flexural Modulus ³	2100	MPa	ASTM D790
Flexural Modulus ⁴	2250	MPa	ISO 178
Flexural Strength ³	65.0	MPa	ASTM D790
Flexural Stress ⁴	72.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (23°C)	25	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C, 6.35 mm)	280	J/m	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	106		ASTM D785
Rockwell Hardness (R-Scale)	106		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/B
0.45 MPa, Unannealed, 4.00 mm	97.0	°C	
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm	92.0	°C	

UL and the UL logo are trademarks of UL LLC © 2022. All Rights Reserved.

The information presented here was acquired by UL from the producer of the product or material or original information provider. However, UL assumes no responsibility or liability for the accuracy of the information contained on this website and strongly encourages that upon final product or material selection information is validated with the manufacturer. This website provides links to other websites owned by third parties. The content of such third party sites is not within our control, and we cannot and will not take responsibility for the information or content.

Starex BM-0320JM

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	80 to 90	°C
Hot Air Dryer	80 to 90	°C
Drying Time		
Desiccant Dryer	3.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	< 0.10	%
Rear Temperature	180 to 210	°C
Middle Temperature	190 to 220	°C
Front Temperature	210 to 230	°C
Nozzle Temperature	220 to 250	°C
Mold Temperature	40 to 80	°C
Injection Pressure	49.0 to 147	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 230 to 260°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 50 mm/min

³ 2.8 mm/min

⁴ 2.0 mm/min

⁵ 4mm

STAVIAN[®]
CHEMICAL