



# Starex SD-0150GP

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

Wednesday, March 9, 2022

## General Information

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
RoHS Compliance	• RoHS Compliant		
Automotive Specifications	• GM GMW15572P-ABS-T1	• IMDS ID 442694363	

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.04		ASTM D792
Density (Natural)	1.04	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	1.8	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	1.8	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	334000	psi	ISO 527-1/50
Tensile Strength <sup>2</sup> (Yield)	5080	psi	ASTM D638
Tensile Stress (Yield)	5080	psi	ISO 527-2/50
Tensile Stress (Break)	4790	psi	ISO 527-2/50
Tensile Strain (Break)	14	%	ISO 527-2/50
Flexural Modulus <sup>3</sup>	305000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	319000	psi	ISO 178
Flexural Strength <sup>3</sup>	8410	psi	ASTM D790
Flexural Stress <sup>4</sup>	9430	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	12	ft-lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.250 in)	5.2	ft-lb/in	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (73°F)	10	ft-lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Rockwell Hardness (R-Scale)	105		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	194	°F	ISO 75-2/B
Deflection Temperature Under Load 66 psi, Annealed, 0.157 in	210	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	174	°F	ISO 75-2/A

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## Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Annealed, 0.157 in	203	°F	ISO 75-2/A
Vicat Softening Temperature	210	°F	ISO 306/B120
--	207	°F	ISO 306/B50

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	185 to 203	°F
Hot Air Dryer	185 to 203	°F
Drying Time		
Desiccant Dryer	2.0 to 4.0	hr
Hot Air Dryer	2.0 to 4.0	hr
Suggested Max Moisture	< 0.10	%
Rear Temperature	356 to 392	°F
Middle Temperature	392 to 410	°F
Front Temperature	410 to 446	°F
Nozzle Temperature	428 to 464	°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 to 210°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