



Starex SR-0340M

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
Automotive Specifications	• HYUNDAI MS225-18 T5	• RENAULT SM 200-01 ABS	

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.07		ASTM D792
Density (Natural)	1.07	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	2.5	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	2.5	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.40 to 0.70	%	
Flow : 0.0787 in	0.40 to 0.70	%	
Water Absorption (Saturation, 73°F)	0.050	%	ASTM D570
Water Absorption (Saturation, 73°F)	0.050	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	6090	psi	ASTM D638
Tensile Stress (Yield)	6820	psi	ISO 527-2/50
Tensile Elongation ² (Break)	14	%	ASTM D638
Tensile Strain (Break)	14	%	ISO 527-2/50
Flexural Modulus ³	319000	psi	ASTM D790
Flexural Modulus ⁴	363000	psi	ISO 178
Flexural Strength ³	9140	psi	ASTM D790
Flexural Stress ⁴	11300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	6.2	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	3.0	ft-lb/in	
73°F, 0.250 in	2.6	ft-lb/in	
Notched Izod Impact Strength ⁵ (73°F)	6.7	ft-lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Rockwell Hardness (R-Scale)	110		ISO 2039-2

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Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	248	°F	ISO 306/B50

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	194	°F
Hot Air Dryer	194	°F
Drying Time		
Desiccant Dryer	2.0 to 3.0	hr
Hot Air Dryer	3.0 to 4.0	hr
Suggested Max Moisture	< 0.10	%
Rear Temperature	374 to 419	°F
Middle Temperature	419 to 455	°F
Front Temperature	446 to 482	°F
Nozzle Temperature	464 to 509	°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: 220 to 240°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

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