Starex TX-0510

Lotte Chemical Corporation - Methyl Methacrylate / ABS

Wednesday, March 9, 2022

General Information

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

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.10	g/cm³	ASTM D792
Density (Natural)	1.10	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	16	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	16	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.43 to 0.52	%	ASTM D955
Molding Shrinkage - Across Flow (3.20 mm)	0.44 to 0.54	%	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	0.44 to 0.54	%	
Flow : 2.00 mm	0.43 to 0.52	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus [2]	2000	MPa	ASTM D638
Tensile Strength [2] (Yield)	44.0	MPa	ASTM D638
Tensile Stress (Yield)	47.0	MPa	ISO 527-2/50
Tensile Strength [2] (Break)	32.0	MPa	ASTM D638
Tensile Elongation [2] (Break)	19	%	ASTM D638
Flexural Modulus [3]	2100	MPa	ASTM D790
Flexural Modulus [4]	2200	MPa	ISO 178
Flexural Strength [3]	64.0	MPa	ASTM D790
Flexural Stress [4]	70.0	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (23°C)	13	kJ/m²	ISO 179/1eA
Notched Izod Impact			ASTM D256
23°C, 3.18 mm	150	J/m	
23°C, 6.35 mm	150	J/m	
Notched Izod Impact Strength [5] (23°C)	12	kJ/m²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	109		ASTM D785
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm	78.0	°C	
Vicat Softening Temperature	88.0	°C	ISO 306/B50

powered by PROSPECTOR®
www.ulprospector.com

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 TX-0510

Lotte Chemical Corporation - Methyl Methacrylate / ABS

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.5 mm	HB		
3.0 mm	HB		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	80	°C
Hot Air Dryer	80	°C
Drying Time		
Desiccant Dryer	2.0	hr
Hot Air Dryer	2.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	200 to 215	°C
Middle Temperature	215	°C
Front Temperature	215 to 230	°C
Nozzle Temperature	230	°C
Mold Temperature	40 to 60	°C
Injection Pressure	49.0 to 196	MPa
Back Pressure	0.490 to 4.90	MPa
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] 5.0 mm/min

[3] 2.8 mm/min

[4] 2.0 mm/min

[5] 4mm

STAVIAN® CHEMICAL

powered by PROSPECTOR®
www.ulprospector.com

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.