

# Starex TX-0510T

Lotte Chemical Corporation - Methyl Methacrylate / ABS

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 <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.10	g/cm <sup>3</sup>	ASTM D792
Density (Natural)	1.10	g/cm <sup>3</sup>	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
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ISO 527-1/50
Tensile Strength <sup>2</sup> (Yield)	44.0	MPa	ASTM D638
Tensile Stress (Yield)	47.0	MPa	ISO 527-2/50
Tensile Stress (Break)	35.0	MPa	ISO 527-2/50
Tensile Strain (Break)	16	%	ISO 527-2/50
Flexural Modulus <sup>3</sup>	2100	MPa	ASTM D790
Flexural Modulus <sup>4</sup>	2200	MPa	ISO 178
Flexural Strength <sup>3</sup>	64.0	MPa	ASTM D790
Flexural Stress <sup>4</sup>	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (23°C)	13	kJ/m <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (23°C, 3.18 mm)	150	J/m	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (23°C)	12	kJ/m <sup>2</sup>	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 0.45 MPa, Unannealed, 4.00 mm	83.0	°C	ISO 75-2/B
Deflection Temperature Under Load 0.45 MPa, Annealed, 4.00 mm	86.0	°C	ISO 75-2/B
Deflection Temperature Under Load 1.8 MPa, Unannealed, 4.00 mm	70.0	°C	ISO 75-2/A
Deflection Temperature Under Load 1.8 MPa, Annealed, 4.00 mm	80.0	°C	ISO 75-2/A
Vicat Softening Temperature	88.0	°C	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.5 mm		HB	
3.0 mm		HB	

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## Lotte Chemical Corporation - Methyl Methacrylate / ABS

Optical	Nominal Value	Unit	Test Method
Light Transmittance (81280 µm)	88.0	%	ASTM D1003
Haze (3200 µm)	2.80	%	ASTM D1003

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	80	°C
Hot Air Dryer	80	°C
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	180 to 190	°C
Middle Temperature	200 to 210	°C
Front Temperature	220 to 230	°C
Nozzle Temperature	230	°C
Mold Temperature	50 to 70	°C
Injection Pressure	49.0 to 196	MPa
Back Pressure	0.490 to 1.96	MPa
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> 5.0 mm/min

<sup>3</sup> 2.8 mm/min

<sup>4</sup> 2.0 mm/min

<sup>5</sup> 4mm

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