

STAREX GR-4020

ABS-GF

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	7	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
ASTM Data			
Melt Flow Index, MFI	7	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.002	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Modulus	5600	MPa	ISO 527
Yield stress	85	MPa	ISO 527
Stress at break	101	MPa	ISO 527
Strain at break	2.8	%	ISO 527
Flexural modulus, 23°C	5700	MPa	ISO 178
Flexural strength	110	MPa	ISO 178
Charpy notched impact strength, +23°C	9	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	8	kJ/m ²	ISO 180/1A
Rockwell hardness	R 114	-	ISO 2039-2
ASTM Data			
Tensile Modulus	5300	MPa	ASTM D 638
Tensile Strength at Yield	78	MPa	ASTM D 638
Tensile Strength at Break	93	MPa	ASTM D 638
Elongation at Break	2.9	%	ASTM D 638
Flexural Modulus	4800	MPa	ASTM D 790
Flexural Strength	88	MPa	ASTM D 790
Rockwell Hardness	R 112	-	ASTM D 785
Izod Impact notched, 1/8 in	59	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	101	°C	ISO 75-1/-2
Vicat softening temperature, B	107	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	101	°C	ASTM D 648
Other properties			
Value			
Density	1180	kg/m ³	ISO 1183
Density	1180	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Value			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	235	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	180 - 190	°C	-
Zone 2	200 - 210	°C	-
Zone 3	220 - 230	°C	-

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Nozzle temperature	240	°C	-
Screw speed	50 - 150	rpm	-
Injection pressure	49 - 250	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color