

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	22	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	22	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0027	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0027	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Modulus	4700	MPa	ISO 527
Yield stress	75	MPa	ISO 527
Stress at break	75	MPa	ISO 527
Strain at break	3	%	ISO 527
Flexural modulus, 23°C	5700	MPa	ISO 178
Flexural strength	110	MPa	ISO 178
Charpy notched impact strength, +23°C	8	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	6	kJ/m ²	ISO 180/1A
Rockwell hardness	R 110	-	ISO 2039-2
ASTM Data			
Tensile Modulus	4500	MPa	ASTM D 638
Tensile Strength at Yield	74	MPa	ASTM D 638
Tensile Strength at Break	67	MPa	ASTM D 638
Elongation at Break	3	%	ASTM D 638
Flexural Modulus	5200	MPa	ASTM D 790
Flexural Strength	98	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	97	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	105	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 66 psi	106	°C	ASTM D 648
DTUL @ 264 psi	99	°C	ASTM D 648
Other properties			
Density	1150	kg/m ³	ISO 1183
Density	1150	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	240	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	170 - 190	°C	-
Zone 2	200 - 210	°C	-
Zone 3	220 - 230	°C	-
Nozzle temperature	240	°C	-
Screw speed	50 - 150	rpm	-
Injection pressure	49 - 150	MPa	-

STAREX GR-4615

ABS-GF

Lotte Chemical Corporation

Back pressure

0.5 - 2

MPa

-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color