

STAREX VG-4920

ABS-GF

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	25	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	25	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	6300	MPa	ISO 527
Yield stress	100	MPa	ISO 527
Stress at break	100	MPa	ISO 527
Strain at break	3	%	ISO 527
Flexural modulus, 23°C	7100	MPa	ISO 178
Flexural strength	130	MPa	ISO 178
Charpy notched impact strength, +23°C	7	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	7	kJ/m ²	ISO 180/1A
Rockwell hardness	R 115	-	ISO 2039-2
ASTM Data			
Tensile Modulus	5700	MPa	ASTM D 638
Tensile Strength at Yield	94	MPa	ASTM D 638
Tensile Strength at Break	94	MPa	ASTM D 638
Elongation at Break	3	%	ASTM D 638
Flexural Modulus	5900	MPa	ASTM D 790
Flexural Strength	100	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785
Izod Impact notched, 1/8 in	49	J/m	ASTM D 256
Izod Impact notched, 1/4 in	49	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	95	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	101	°C	ISO 75-1/-2
Vicat softening temperature, B	101	°C	ISO 306
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 66 psi	101	°C	ASTM D 648
DTUL @ 264 psi	96	°C	ASTM D 648
Other properties			
Value			
Density	1330	kg/m ³	ISO 1183
Density	1330	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