STAREX BM-0320 E

ABS — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**3.3**	g/10min	ISO 1133
Temperature	**220**	°C	-
Load	**10**	kg	-
Molding shrinkage, parallel	**0.4**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.5**	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	**3.3**	g/10min	ASTM D 1238
Temperature	**220**	°C	-
Load	**10**	kg	-
Mold Shrinkage, MD	**0.004**	mm/mm	ASTM D 955
Mold Shrinkage, TD	**0.005**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2100**	MPa	ISO 527
Yield stress	**44**	MPa	ISO 527
Stress at break	**35**	MPa	ISO 527
Strain at break	**15**	%	ISO 527
Flexural modulus, 23°C	**2300**	MPa	ISO 178
Flexural strength	**70**	MPa	ISO 178
Charpy notched impact strength, +23°C	**20**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**20**	kJ/m²	ISO 180/1A
Rockwell hardness	**R 105**	-	ISO 2039-2
ASTM Data			
Tensile Modulus	**2000**	MPa	ASTM D 638
Tensile Strength at Yield	**44**	MPa	ASTM D 638
Tensile Strength at Break	**34**	MPa	ASTM D 638
Elongation at Break	**15**	%	ASTM D 638
Flexural Modulus	**2000**	MPa	ASTM D 790
Flexural Strength	**61**	MPa	ASTM D 790
Rockwell Hardness	**R 105**	-	ASTM D 785
Izod Impact notched, 1/8 in	**200**	J/m	ASTM D 256
Izod Impact notched, 1/4 in	**150**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**86**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**98**	°C	ISO 75-1/-2
Vicat softening temperature, B	**108**	°C	ISO 306
ASTM Data			
DTUL @ 66 psi	**107**	°C	ASTM D 648
DTUL @ 264 psi	**97**	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	**1050**	kg/m³	ISO 1183
Density	**1050**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80**	°C	-
Pre-drying - Time	**4**	h	-
Processing humidity	**≤0.02**	%	-
Mold temperature	**60**	°C	-
Zone 1	**230**	°C	-
Zone 2	**240**	°C	-
Zone 3	**250**	°C	-
Nozzle temperature	**240**	°C	-

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Screw speed	**100**	rpm	-
Injection pressure	**270**	MPa	-
Back pressure	**98 - 130**	MPa	-

Characteristics

Processing
Injection Molding

Delivery form
Pellets, Natural Color

Regional Availability
North America, Europe, Asia Pacific

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