

STAREX BM-0320JM

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	6	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	6	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0045	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0045	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Yield stress	44	MPa	ISO 527
Strain at break	15	%	ISO 527
Flexural modulus, 23°C	2250	MPa	ISO 178
Flexural strength	72	MPa	ISO 178
Charpy notched impact strength, +23°C	25	kJ/m ²	ISO 179/1eA
Rockwell hardness	R 106	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	46	MPa	ASTM D 638
Tensile Strength at Break	43	MPa	ASTM D 638
Elongation at Break	15	%	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	65	MPa	ASTM D 790
Rockwell Hardness	R 106	-	ASTM D 785
Izod Impact notched, 1/4 in	280	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 0.45 MPa	97	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 264 psi	92	°C	ASTM D 648
Other properties			
Density	1040	kg/m ³	ISO 1183
Density	1040	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	230 - 260	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	180 - 210	°C	-
Zone 2	190 - 220	°C	-
Zone 3	210 - 230	°C	-
Nozzle temperature	220 - 250	°C	-
Screw speed	50 - 150	rpm	-
Injection pressure	49 - 150	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics

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Processing

Injection Molding

Applications

Automotive

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific