

**STAREX CM-0140 M**

ABS

Lotte Chemical Corporation

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	7	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	7	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.003	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.003	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Tensile Modulus	2450	MPa	ISO 527
Yield stress	36	MPa	ISO 527
Stress at break	35	MPa	ISO 527
Strain at break	20	%	ISO 527
Flexural modulus, 23°C	2600	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Charpy notched impact strength, +23°C	14	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	11	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 115	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Modulus	2400	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	20	%	ASTM D 638
Flexural Modulus	2400	MPa	ASTM D 790
Flexural Strength	69	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	140	J/m	ASTM D 256
Izod Impact notched, 1/4 in	98	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Temp. of deflection under load, 1.80 MPa	75	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	87	°C	ISO 75-1/-2
Vicat softening temperature, B	95	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	1.0	mm	-
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1	mm	-
DTUL @ 66 psi	98	°C	ASTM D 648
DTUL @ 264 psi	84	°C	ASTM D 648
<b>Optical properties</b>			
<b>ASTM Data</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Gloss	80	-	ASTM D 2457
<b>Other properties</b>			
<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>	
Density	1050	kg/m <sup>3</sup>	ISO 1183
Density	1050	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	230	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	160 - 180	°C	-
Zone 2	190 - 200	°C	-
Zone 3	210 - 220	°C	-
Nozzle temperature	230	°C	-
Screw speed	50 - 150	rpm	-
Injection pressure	49 - 150	MPa	-
Back pressure	0.5 - 2	MPa	-

### Characteristics

#### Processing

Injection Molding

#### Regional Availability

North America, Europe, Asia Pacific

#### Delivery form

Pellets, Natural Color