STAREX CM-0140

ABS — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**3.2**	g/10min	ISO 1133
Temperature	**200**	°C	-
Load	**5**	kg	-
ASTM Data			
Melt Flow Index, MFI	**3.2**	g/10min	ASTM D 1238
Temperature	**200**	°C	-
Load	**5**	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2200**	MPa	ISO 527
Yield stress	**45**	MPa	ISO 527
Stress at break	**35**	MPa	ISO 527
Strain at break	**14**	%	ISO 527
Flexural modulus, 23°C	**2400**	MPa	ISO 178
Flexural strength	**73**	MPa	ISO 178
Charpy notched impact strength, +23°C	**26**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**24**	kJ/m²	ISO 180/1A
Rockwell hardness	**R 109**	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	**39**	MPa	ASTM D 638
Flexural Modulus	**2200**	MPa	ASTM D 790
Flexural Strength	**61**	MPa	ASTM D 790
Rockwell Hardness	**R 106**	-	ASTM D 785
Izod Impact notched, 1/4 in	**220**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**76**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**88**	°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	-
ASTM Data			
UL 94 Flame rating	**HB**	-	UL 94
Thickness tested	**1**	mm	-
DTUL @ 264 psi	**81**	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	**1040**	kg/m³	ISO 1183
Density	**1040**	kg/m³	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	-
Nozzle temperature	**230**	°C	-
Screw speed	**50 - 150**	rpm	-
Injection pressure	**49 - 150**	MPa	-
Back pressure	**0.5 - 2**	MPa	-

Copyright Altair Engineering GmbH. Altair Engineering GmbH assumes no liability for the system to be free of errors. The user takes sole responsibility for the use of this data under the exclusion of every liability from Altair Engineering GmbH; this is especially valid for claims of compensation resulting from consequential damages. Altair explicitly points out that any decision about the application of materials must be double checked with the producer of this material. This includes all contents of this system. Copyright laws are applicable for the content of this system.

Characteristics

Processing
Injection Molding

Delivery form
Pellets, Natural Color

Regional Availability
North America, Europe, Asia Pacific

Copyright Altair Engineering GmbH. Altair Engineering GmbH assumes no liability for the system to be free of errors. The user takes sole responsibility for the use of this data under the exclusion of every liability from Altair Engineering GmbH; this is especially valid for claims of compensation resulting from consequential damages. Altair explicitly points out that any decision about the application of materials must be double checked with the producer of this material. This includes all contents of this system. Copyright laws are applicable for the content of this system.