

**STAREX GR-4017**

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	17.2	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
<b>ASTM Data</b>			
Melt Flow Index, MFI	17.2	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.003	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	5200	MPa	ISO 527
Yield stress	93	MPa	ISO 527
Stress at break	93	MPa	ISO 527
Strain at break	3	%	ISO 527
Flexural modulus, 23°C	5800	MPa	ISO 178
Flexural strength	131	MPa	ISO 178
Charpy notched impact strength, +23°C	8.6	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	8	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 117	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Strength at Yield	77	MPa	ASTM D 638
Flexural Modulus	5000	MPa	ASTM D 790
Flexural Strength	120	MPa	ASTM D 790
Rockwell Hardness	R 117	-	ASTM D 785
Izod Impact notched, 1/8 in	79	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	100	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	105	°C	ISO 75-1/-2
Vicat softening temperature, B	105	°C	ISO 306
<b>ASTM Data</b>			
DTUL @ 264 psi	100	°C	ASTM D 648
<b>Other properties</b>			
Density	1170	kg/m <sup>3</sup>	ISO 1183
Density	1170	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	90 - 100	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	215 - 235	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	190 - 200	°C	-
Zone 2	200 - 215	°C	-
Zone 3	215 - 235	°C	-
Nozzle temperature	225 - 255	°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