

**STAREX HF-0680 U**

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	2.2	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
<b>ASTM Data</b>			
Melt Flow Index, MFI	2.2	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Yield stress	49	MPa	ISO 527
Flexural modulus, 23°C	2600	MPa	ISO 178
Flexural strength	59	MPa	ISO 178
Charpy notched impact strength, +23°C	21	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	19	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 110	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Strength at Yield	44	MPa	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	61	MPa	ASTM D 790
Rockwell Hardness	R 108	-	ASTM D 785
Izod Impact notched, 1/4 in	230	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Vicat softening temperature, B	97	°C	ISO 306
<b>Other properties</b>			
Density	1040	kg/m <sup>3</sup>	ISO 1183
Density	1040	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
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

**Delivery form**

Pellets, Natural Color

**Regional Availability**

North America, Europe, Asia Pacific