

STAREX HF-0680

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	5.5	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
ASTM Data			
Melt Flow Index, MFI	5.5	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mechanical properties			
ISO Data			
Yield stress	40	MPa	ISO 527
Flexural modulus, 23°C	1900	MPa	ISO 178
Flexural strength	60	MPa	ISO 178
Charpy notched impact strength, +23°C	18	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	20	kJ/m ²	ISO 180/1A
Rockwell hardness	R 107	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	41	MPa	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	62	MPa	ASTM D 790
Rockwell Hardness	R 107	-	ASTM D 785
Izod Impact notched, 1/4 in	200	J/m	ASTM D 256
Thermal properties			
ISO Data			
Vicat softening temperature, B	97	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	85	°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	°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

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Processing

Injection Molding

Applications

IT / Business Machine

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific