

STAREX HF-0690 M

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	8.5	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
ASTM Data			
Melt Flow Index, MFI	8.5	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mechanical properties			
ISO Data			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	40	MPa	ISO 527
Stress at break	32	MPa	ISO 527
Strain at break	25	%	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	58	MPa	ISO 178
Charpy notched impact strength, +23°C	19	kJ/m ²	ISO 179/1eA
Rockwell hardness	R 104	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2300	MPa	ASTM D 638
Tensile Strength at Yield	39	MPa	ASTM D 638
Tensile Strength at Break	32	MPa	ASTM D 638
Elongation at Break	20	%	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	57	MPa	ASTM D 790
Rockwell Hardness	R 104	-	ASTM D 785
Izod Impact notched, 1/4 in	190	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	73	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	84	°C	ISO 75-1/-2
Vicat softening temperature, B	94	°C	ISO 306
ASTM Data			
DTUL @ 66 psi	90	°C	ASTM D 648
DTUL @ 264 psi	82	°C	ASTM D 648
Optical properties			
ASTM Data			
Gloss	108	-	ASTM D 2457
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	-

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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