

**STAREX HP-0500**

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	16	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
<b>ASTM Data</b>			
Melt Flow Index, MFI	16	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	2600	MPa	ISO 527
Yield stress	40	MPa	ISO 527
Stress at break	41	MPa	ISO 527
Strain at break	11	%	ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	60	MPa	ISO 178
Charpy notched impact strength, +23°C	14	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	13	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 114	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Modulus	2600	MPa	ASTM D 638
Tensile Strength at Yield	47	MPa	ASTM D 638
Tensile Strength at Break	20	MPa	ASTM D 638
Elongation at Break	39	%	ASTM D 638
Flexural Modulus	2300	MPa	ASTM D 790
Flexural Strength	69	MPa	ASTM D 790
Rockwell Hardness	R 114	-	ASTM D 785
Izod Impact notched, 1/8 in	130	J/m	ASTM D 256
Izod Impact notched, 1/4 in	130	J/m	ASTM D 256

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	82	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	96	°C	ISO 75-1/-2
Vicat softening temperature, B	100	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 66 psi	99	°C	ASTM D 648
DTUL @ 264 psi	91	°C	ASTM D 648

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	1050	kg/m <sup>3</sup>	ISO 1183
Density	1050	kg/m <sup>3</sup>	ASTM D 792

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</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	-

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Nozzle temperature	<b>230</b>	°C	-
Screw speed	<b>50 - 150</b>	rpm	-
Injection pressure	<b>49 - 150</b>	MPa	-
Back pressure	<b>0.5 - 2</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Delivery form**

Pellets, Natural Color