

STAREX LM-0990

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	15	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.8	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	15	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0075	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0069	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2240	MPa	ISO 527
Yield stress	50	MPa	ISO 527
Stress at break	35	MPa	ISO 527
Strain at break	14	%	ISO 527
Flexural modulus, 23°C	2240	MPa	ISO 178
Flexural strength	70	MPa	ISO 178
Charpy notched impact strength, +23°C	12	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	13	kJ/m ²	ISO 180/1A
Rockwell hardness	R112	-	ISO 2039-2
ASTM Data			
Tensile Modulus	1700	MPa	ASTM D 638
Tensile Strength at Yield	48	MPa	ASTM D 638
Tensile Strength at Break	29	MPa	ASTM D 638
Elongation at Break	20	%	ASTM D 638
Flexural Modulus	2000	MPa	ASTM D 790
Flexural Strength	60	MPa	ASTM D 790
Rockwell Hardness	R 107	-	ASTM D 785
Izod Impact notched, 1/8 in	140	J/m	ASTM D 256
Izod Impact notched, 1/4 in	120	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	650	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	70	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	82	°C	ISO 75-1/-2
Vicat softening temperature, B	88	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	3	mm	-
DTUL @ 264 psi	81	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1100	kg/m ³	ISO 1183
Density	1100	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	230	°C	-
Mold temperature	40 - 80	°C	-

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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

Applications

Electrical and Electronical

Regional Availability

North America, Europe, Asia Pacific