

**STAREX LX-0915G**

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	17	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.1	%	ISO 294-4, 2577
Molding shrinkage, normal	0.1	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	17	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.001	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.001	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	6000	MPa	ISO 527
Yield stress	79	MPa	ISO 527
Stress at break	718	MPa	ISO 527
Strain at break	3	%	ISO 527
Flexural modulus, 23°C	4810	MPa	ISO 178
Flexural strength	103	MPa	ISO 178
Charpy notched impact strength, +23°C	7	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	6.5	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 112	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Modulus	5600	MPa	ASTM D 638
Tensile Strength at Yield	66	MPa	ASTM D 638
Tensile Strength at Break	74	MPa	ASTM D 638
Elongation at Break	30	%	ASTM D 638
Flexural Modulus	4700	MPa	ASTM D 790
Flexural Strength	93	MPa	ASTM D 790
Rockwell Hardness	R 112	-	ASTM D 785
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	97	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	100	°C	ISO 75-1/-2
Vicat softening temperature, B	101	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 66 psi	100	°C	ASTM D 648
DTUL @ 264 psi	97	°C	ASTM D 648
<b>Other properties</b>			
Density	1150	kg/m <sup>3</sup>	ISO 1183
Density	1150	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2	h	-
Processing humidity	≤0.07	%	-
Melt temperature	245	°C	-

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Mold temperature	<b>60</b>	°C	-
Zone 1	<b>225</b>	°C	-
Zone 2	<b>225</b>	°C	-
Zone 3	<b>235 - 245</b>	°C	-
Nozzle temperature	<b>255</b>	°C	-
Screw speed	<b>50 - 100</b>	rpm	-
Injection pressure	<b>93</b>	MPa	-
Back pressure	<b>0.5 - 2.9</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Delivery form**

Pellets, Natural Color