

STAREX LX-0981M

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	5	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	5	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.0045	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0045	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Yield stress	50	MPa	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	70	MPa	ISO 178
Charpy notched impact strength, +23°C	13	kJ/m ²	ISO 179/1eA
Rockwell hardness	R 111	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2200	MPa	ASTM D 638
Tensile Strength at Yield	44	MPa	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	61	MPa	ASTM D 790
Rockwell Hardness	R 109	-	ASTM D 785
Izod Impact notched, 1/8 in	150	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	79	°C	ISO 75-1/-2
Vicat softening temperature, B	94	°C	ISO 306
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 66 psi	89	°C	ASTM D 648
DTUL @ 264 psi	82	°C	ASTM D 648
Other properties			
Density	1060	kg/m ³	ISO 1183
Density	1060	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	250	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	200 - 220	°C	-
Zone 2	220 - 230	°C	-
Zone 3	230 - 240	°C	-
Nozzle temperature	250	°C	-
Screw speed	50 - 90	rpm	-
Injection pressure	98	MPa	-
Back pressure	1 - 2	MPa	-

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Characteristics

Processing

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color