

STAREX LX-9140

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	3	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	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	3	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0048	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0051	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Modulus	2000	MPa	ISO 527
Yield stress	45	MPa	ISO 527
Stress at break	34	MPa	ISO 527
Strain at break	18	%	ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Flexural strength	66	MPa	ISO 178
Charpy notched impact strength, +23°C	9	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	6	kJ/m ²	ISO 180/1A
Rockwell hardness	R 96	-	ISO 2039-2
ASTM Data			
Tensile Modulus	1900	MPa	ASTM D 638
Tensile Strength at Yield	42	MPa	ASTM D 638
Tensile Strength at Break	44	MPa	ASTM D 638
Elongation at Break	105	%	ASTM D 638
Flexural Modulus	1900	MPa	ASTM D 790
Flexural Strength	57	MPa	ASTM D 790
Rockwell Hardness	R 96	-	ASTM D 785
Izod Impact notched, 1/8 in	98	J/m	ASTM D 256
Izod Impact notched, 1/4 in	59	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	77	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	91	°C	ISO 75-1/-2
Vicat softening temperature, B	95	°C	ISO 306
ASTM Data			
DTUL @ 66 psi	96	°C	ASTM D 648
DTUL @ 264 psi	84	°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	100	°C	-
Pre-drying - Time	2	h	-
Processing humidity	≤0.07	%	-
Melt temperature	250	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	230	°C	-
Zone 2	250	°C	-
Zone 3	250	°C	-

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Nozzle temperature	250	°C	-
Screw speed	50 - 100	rpm	-
Injection pressure	93	MPa	-
Back pressure	0.5	MPa	-
Holding pressure	2.9	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Electrical and Electronical

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific