

STAREX NH-0927

ABS

Lotte Chemical Corporation

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|--|--------------|-------------------|----------------------|
| ISO Data | | | |
| Melt flow index, MFI | 3.6 | g/10min | ISO 1133 |
| Temperature | 200 | °C | - |
| Load | 5 | kg | - |
| Molding shrinkage, parallel | 0.5 | % | ISO 294-4, 2577 |
| ASTM Data | | | |
| Melt Flow Index, MFI | 3.5 | g/10min | ASTM D 1238 |
| Temperature | 200 | °C | - |
| Load | 5 | kg | - |
| Mold Shrinkage, MD | 0.0045 | mm/mm | ASTM D 955 |
| Mechanical properties | | | |
| ISO Data | | | |
| Tensile Modulus | 2500 | MPa | ISO 527 |
| Yield stress | 50 | MPa | ISO 527 |
| Stress at break | 36 | MPa | ISO 527 |
| Strain at break | 13 | % | ISO 527 |
| Flexural modulus, 23°C | 2600 | MPa | ISO 178 |
| Flexural strength | 78 | MPa | ISO 178 |
| Charpy notched impact strength, +23°C | 21 | kJ/m ² | ISO 179/1eA |
| Izod notched impact strength, +23°C | 21 | kJ/m ² | ISO 180/1A |
| Rockwell hardness | R 112 | - | ISO 2039-2 |
| ASTM Data | | | |
| Tensile Modulus | 2300 | MPa | ASTM D 638 |
| Tensile Strength at Yield | 54 | MPa | ASTM D 638 |
| Tensile Strength at Break | 35 | MPa | ASTM D 638 |
| Elongation at Yield | 25 | % | ASTM D 638 |
| Flexural Modulus | 2600 | MPa | ASTM D 790 |
| Flexural Strength | 66 | MPa | ASTM D 790 |
| Rockwell Hardness | R 110 | - | ASTM D 785 |
| Izod Impact notched, 1/8 in | 180 | J/m | ASTM D 256 |
| Izod Impact notched, 1/4 in | 160 | J/m | ASTM D 256 |
| Thermal properties | | | |
| ISO Data | | | |
| Temp. of deflection under load, 1.80 MPa | 78 | °C | ISO 75-1/-2 |
| Temp. of deflection under load, 0.45 MPa | 90 | °C | ISO 75-1/-2 |
| Vicat softening temperature, B | 96 | °C | ISO 306 |
| Burning behav. at thickness h | V-2 | class | IEC 60695-11-10 |
| Thickness tested | 1.0 | mm | - |
| ASTM Data | | | |
| UL 94 Flame rating | V-2 | - | UL 94 |
| Thickness tested | 1 | mm | - |
| DTUL @ 66 psi | 94 | °C | ASTM D 648 |
| DTUL @ 264 psi | 88 | °C | ASTM D 648 |
| Other properties | | | |
| Density | 1060 | kg/m ³ | ISO 1183 |
| Density | 1050 | kg/m ³ | ASTM D 792 |
| Processing Recommendation Injection Molding | | | |
| 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 | - |

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| | | | |
|--------------------|------------------|-----|---|
| 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

Special Characteristics

Flame retardant

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific