

STAREX PT-0180 H

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	2.3	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
ASTM Data			
Melt Flow Index, MFI	2.3	g/10min	ASTM D 1238
Temperature	200	°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	Value	Unit	Test Standard
ISO Data			
Yield stress	42	MPa	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	66	MPa	ISO 178
Charpy notched impact strength, +23°C	32	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	32	kJ/m ²	ISO 180/1A
Rockwell hardness	R 105	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2000	MPa	ASTM D 638
Tensile Strength at Yield	37	MPa	ASTM D 638
Flexural Strength	59	MPa	ASTM D 790
Rockwell Hardness	R 105	-	ASTM D 785
Izod Impact notched, 1/4 in	320	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Vicat softening temperature, B	97	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	84	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1040	kg/m ³	ISO 1183
Density	1040	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	85 - 95	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	210 - 230	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	180 - 200	°C	-
Zone 2	200 - 210	°C	-
Zone 3	210 - 230	°C	-
Nozzle temperature	220 - 240	°C	-
Screw speed	50 - 150	rpm	-
Injection pressure	49 - 150	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive

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Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific