

STAREX PT-0180J

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	28	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
Density of melt	0.45	kg/m ³	-
ASTM Data			
Melt Flow Index, MFI	28	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	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			
Tensile Modulus	2300	MPa	ISO 527
Yield stress	44	MPa	ISO 527
Stress at break	44	MPa	ISO 527
Strain at break	23	%	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	69	MPa	ISO 178
Charpy notched impact strength, +23°C	26	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	27	kJ/m ²	ISO 180/1A
Rockwell hardness	R 109	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2300	MPa	ASTM D 638
Tensile Strength at Yield	44	MPa	ASTM D 638
Tensile Strength at Break	44	MPa	ASTM D 638
Elongation at Break	23	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	66	MPa	ASTM D 790
Rockwell Hardness	R 109	-	ASTM D 785
Izod Impact unnotched, 1/8 in	280	J/m	ASTM D 256
Izod Impact unnotched, 1/4 in	270	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	79	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	94	°C	ISO 75-1/-2
Vicat softening temperature, B	99	°C	ISO 306
ASTM Data			
DTUL @ 66 psi	101	°C	ASTM D 648
DTUL @ 264 psi	86	°C	ASTM D 648
Other properties			
Value			
Density	1040	kg/m ³	ISO 1183
Density	1040	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Value			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	220	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	190	°C	-
Zone 2	200	°C	-

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Zone 3	220	°C	-
Nozzle temperature	220	°C	-
Screw speed	30 - 80	rpm	-
Injection pressure	78	MPa	-
Back pressure	1 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific