

STAREX SD-0190H

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	8.5	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
ASTM Data			
Melt Flow Index, MFI	8.5	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	1800	MPa	ISO 527
Yield stress	35	MPa	ISO 527
Stress at break	30	MPa	ISO 527
Strain at break	18	%	ISO 527
Flexural modulus, 23°C	1700	MPa	ISO 178
Flexural strength	50	MPa	ISO 178
Charpy notched impact strength, +23°C	43	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	42	kJ/m ²	ISO 180/1A
Rockwell hardness	R 93	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	34	MPa	ASTM D 638
Flexural Modulus	1700	MPa	ASTM D 790
Flexural Strength	47	MPa	ASTM D 790
Rockwell Hardness	R 93	-	ASTM D 785
Izod Impact notched, 1/4 in	390	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	74	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	92	°C	ISO 75-1/-2
Vicat softening temperature, B	95	°C	ISO 306

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	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	-
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

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color