

STAREX SP-0183

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	3.9	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	3.9	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0045	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0052	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Modulus	2000	MPa	ISO 527
Yield stress	42	MPa	ISO 527
Stress at break	40	MPa	ISO 527
Strain at break	14	%	ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Flexural strength	64	MPa	ISO 178
Izod notched impact strength, +23°C	40	kJ/m ²	ISO 180/1A
Rockwell hardness	R 100	-	ISO 2039-2
ASTM Data			
Tensile Modulus	1900	MPa	ASTM D 638
Tensile Strength at Yield	41	MPa	ASTM D 638
Tensile Strength at Break	33	MPa	ASTM D 638
Elongation at Break	50	%	ASTM D 638
Flexural Modulus	2000	MPa	ASTM D 790
Flexural Strength	63	MPa	ASTM D 790
Rockwell Hardness	R 100	-	ASTM D 785
Izod Impact notched, 1/4 in	400	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	81	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	94	°C	ISO 75-1/-2
Vicat softening temperature, B	101	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	91	°C	ASTM D 648
Other properties			
Density	1040	kg/m ³	ISO 1183
Density	1040	kg/m ³	ASTM D 792
Processing Recommendation Extrusion			
Type of extrusion	pipe/tube	-	-
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	-

STAREX SP-0183

ABS

Lotte Chemical Corporation

Characteristics

Processing

Injection Molding, Pipe/Tube Extrusion

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color