

STAREX SR-0310FM

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	20	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
ASTM Data			
Melt Flow Index, MFI	20	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0055	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0055	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	50	MPa	ISO 527
Stress at break	36	MPa	ISO 527
Strain at break	35	%	ISO 527
Flexural modulus, 23°C	2600	MPa	ISO 178
Flexural strength	78	MPa	ISO 178
Charpy notched impact strength, +23°C	20	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	20	kJ/m ²	ISO 180/1A
Rockwell hardness	R 109	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	39	MPa	ASTM D 638
Elongation at Break	35	%	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	63	MPa	ASTM D 790
Rockwell Hardness	R 109	-	ASTM D 785
Izod Impact notched, 1/4 in	150	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	78	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	97	°C	ISO 75-1/-2
Vicat softening temperature, B	103	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	90	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Water absorption	0.3	%	Sim. to ISO 62
Density	1060	kg/m ³	ISO 1183
Density	1060	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	90	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	220 - 230	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	190 - 205	°C	-
Zone 2	205 - 225	°C	-
Zone 3	225 - 245	°C	-
Nozzle temperature	230 - 260	°C	-
Screw speed	50 - 150	rpm	-
Injection pressure	49 - 150	MPa	-
Back pressure	0.5 - 2	MPa	-

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Characteristics**Processing**

Injection Molding

Applications

Automotive

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific