

STAREX SR-0320 K

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	9	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	9	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			
ISO Data			
Yield stress	48	MPa	ISO 527
Strain at break	36	%	ISO 527
Flexural modulus, 23°C	2450	MPa	ISO 178
Flexural strength	76	MPa	ISO 178
Charpy notched impact strength, +23°C	15	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	17	kJ/m ²	ISO 180/1A
Rockwell hardness	R 110	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	41	MPa	ASTM D 638
Elongation at Break	35	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	64	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785
Izod Impact notched, 1/4 in	170	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	86	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	100	°C	ISO 75-1/-2
Vicat softening temperature, B	106	°C	ISO 306
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	94	°C	ASTM D 648
Other properties			
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			
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

-

Characteristics**Processing**

Injection Molding

Applications

Automotive, Electrical and Electronical

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific