

STAREX SR-0320

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	7.2	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	7.2	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	Value	Unit	Test Standard
Tensile Modulus	2300	MPa	ISO 527
Yield stress	45	MPa	ISO 527
Stress at break	37	MPa	ISO 527
Strain at break	22	%	ISO 527
Flexural modulus, 23°C	2450	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Charpy notched impact strength, +23°C	16.2	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	18.2	kJ/m ²	ISO 180/1A
Rockwell hardness	R 109	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	45	MPa	ASTM D 638
Elongation at Break	15	%	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	66	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785
Izod Impact notched, 1/8 in	180	J/m	ASTM D 256
Izod Impact notched, 1/4 in	180	J/m	ASTM D 256
Thermal properties			
ISO Data	Value	Unit	Test Standard
Temp. of deflection under load, 1.80 MPa	87	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	100	°C	ISO 75-1/-2
Vicat softening temperature, B	107	°C	ISO 306
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	93	°C	ASTM D 648
Other properties			
Value	Unit	Test Standard	
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	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 - 240	°C	-
Nozzle temperature	240	°C	-

STAREX SR-0320

ABS

Lotte Chemical Corporation

Screw speed	50 - 150	rpm	-
Injection pressure	49 - 150	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Delivery form

Pellets, Natural Color

Applications

Automotive, Electrical and Electronical

Regional Availability

North America, Europe, Asia Pacific