

STAREX SR-0325

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	7.5	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
ASTM Data			
Melt Flow Index, MFI	7.5	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	2500	MPa	ISO 527
Yield stress	50	MPa	ISO 527
Stress at break	45	MPa	ISO 527
Strain at break	20	%	ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Flexural strength	73	MPa	ISO 178
Charpy notched impact strength, +23°C	12	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	12	kJ/m ²	ISO 180/1A
Rockwell hardness	R 115	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2300	MPa	ASTM D 638
Tensile Strength at Yield	49	MPa	ASTM D 638
Tensile Strength at Break	45	MPa	ASTM D 638
Elongation at Break	20	%	ASTM D 638
Flexural Modulus	2500	MPa	ASTM D 790
Flexural Strength	74	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	92	°C	ISO 75-1/-2
Vicat softening temperature, B	115	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	103	°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 - 90	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	230 - 260	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	190 - 220	°C	-
Zone 2	210 - 230	°C	-
Zone 3	230 - 260	°C	-
Nozzle temperature	230 - 260	°C	-
Screw speed	5 - 20	rpm	-
Injection pressure	49 - 150	MPa	-
Back pressure	4.9 - 15	MPa	-

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Characteristics**Processing**

Injection Molding

Applications

Automotive

Delivery form

Pellets

Regional Availability

North America, Europe, Asia Pacific