

STAREX SR-0325L

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	7	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	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			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	48	MPa	ISO 527
Stress at break	43	MPa	ISO 527
Strain at break	20	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	70	MPa	ISO 178
Charpy notched impact strength, +23°C	13	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	13	kJ/m ²	ISO 180/1A
Rockwell hardness	R 115	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2400	MPa	ASTM D 638
Tensile Strength at Yield	49	MPa	ASTM D 638
Tensile Strength at Break	46	MPa	ASTM D 638
Elongation at Break	20	%	ASTM D 638
Flexural Modulus	2400	MPa	ASTM D 790
Flexural Strength	69	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	93	°C	ISO 75-1/-2
Vicat softening temperature, B	116	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	103	°C	ASTM D 648
Other properties			
Water absorption	0.1	%	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	80 - 90	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	230 - 260	°C	-
Mold temperature	50 - 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	9.8	MPa	-

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Back pressure

4.9 - 15

MPa

-

Characteristics**Processing**

Injection Molding

Applications

Automotive

Delivery form

Pellets

Regional Availability

North America, Europe, Asia Pacific