

STAREX SR-0330L

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	3.5	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	3.5	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			
ISO Data			
Yield stress	51	MPa	ISO 527
Stress at break	48	MPa	ISO 527
Strain at break	17	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	78	MPa	ISO 178
Charpy notched impact strength, +23°C	13	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	14	kJ/m ²	ISO 180/1A
Izod notched impact strength	8	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Rockwell hardness	R 114	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	51	MPa	ASTM D 638
Tensile Strength at Break	49	MPa	ASTM D 638
Elongation at Break	17	%	ASTM D 638
Flexural Modulus	2400	MPa	ASTM D 790
Flexural Strength	71	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact notched, 1/8 in	140	J/m	ASTM D 256
Izod Impact notched, 1/4 in	130	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	98	°C	ISO 75-1/-2
Vicat softening temperature, B	120	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	107	°C	ASTM D 648
Other properties			
Density	1070	kg/m ³	ISO 1183
Density	1070	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	240 - 260	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	200 - 220	°C	-
Zone 2	220 - 230	°C	-
Zone 3	230 - 250	°C	-
Nozzle temperature	240 - 260	°C	-
Screw speed	50 - 150	rpm	-

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Back pressure

0.5 - 2

MPa

-

Characteristics**Processing**

Injection Molding

Applications

Automotive

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific