

STAREX SR-0330M

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	3	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	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	2330	MPa	ISO 527
Yield stress	48	MPa	ISO 527
Stress at break	45	MPa	ISO 527
Strain at break	15	%	ISO 527
Flexural modulus, 23°C	2350	MPa	ISO 178
Flexural strength	78	MPa	ISO 178
Charpy notched impact strength, +23°C	15	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	10	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	14	kJ/m ²	ISO 180/1A
Izod notched impact strength	9	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Rockwell hardness	R 113	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2200	MPa	ASTM D 638
Tensile Strength at Yield	41	MPa	ASTM D 638
Tensile Strength at Break	40	MPa	ASTM D 638
Elongation at Break	17	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	63	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	130	J/m	ASTM D 256
Izod Impact notched, 1/4 in	120	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	59	J/m	ASTM D 256
Temperature	-30	°C	-
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	96	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	112	°C	ISO 75-1/-2
Vicat softening temperature, B	118	°C	ISO 306
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 66 psi	116	°C	ASTM D 648
DTUL @ 264 psi	104	°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	Value	Unit	Test Standard
Pre-drying - Temperature	90	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	220 - 240	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	190 - 215	°C	-
Zone 2	215 - 235	°C	-
Zone 3	230 - 250	°C	-
Nozzle temperature	240 - 265	°C	-
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

Regional Availability

North America, Europe, Asia Pacific