

**STAREX VE-0856 G**

ABS

Lotte Chemical Corporation

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	3.5	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
<b>ASTM Data</b>			
Melt Flow Index, MFI	3.5	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	2300	MPa	ISO 527
Yield stress	47	MPa	ISO 527
Stress at break	37	MPa	ISO 527
Strain at break	8.4	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Izod impact strength, +23°C	12	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	12	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 100	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Strength at Yield	36	MPa	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	56	MPa	ASTM D 790
Rockwell Hardness	R 105	-	ASTM D 785
Izod Impact notched, 1/8 in	140	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	76	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	87	°C	ISO 75-1/-2
Vicat softening temperature, B	92	°C	ISO 306
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	2.1	mm	-
Burning behav. 5V at thickness h	5VA	class	IEC 60695-11-20
Thickness tested	3.0	mm	-
<b>ASTM Data</b>			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	2.1	mm	-
DTUL @ 66 psi	89	°C	ASTM D 648
DTUL @ 264 psi	78	°C	ASTM D 648
<b>Other properties</b>			
Density	1170	kg/m <sup>3</sup>	ISO 1183
Density	1170	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	220	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	160 - 180	°C	-
Zone 2	190 - 200	°C	-
Zone 3	210 - 220	°C	-
Nozzle temperature	220	°C	-
Screw speed	50 - 150	rpm	-

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Injection pressure	<b>49 - 150</b>	MPa	-
Back pressure	<b>0.5 - 2</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Applications**

Electrical and Electronical

**Delivery form**

Pellets, Natural Color

**Regional Availability**

North America, Europe, Asia Pacific