

STAREX VE-0856 U

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	3.6	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	3.6	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.004	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0043	mm/mm	ASTM D 955
Mechanical properties			
ISO Data	Value	Unit	Test Standard
Tensile Modulus	2100	MPa	ISO 527
Yield stress	42	MPa	ISO 527
Stress at break	28	MPa	ISO 527
Strain at break	6	%	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	64	MPa	ISO 178
Charpy notched impact strength, +23°C	23	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	21	kJ/m ²	ISO 180/1A
Rockwell hardness	R 95	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2000	MPa	ASTM D 638
Tensile Strength at Yield	39	MPa	ASTM D 638
Tensile Strength at Break	27	MPa	ASTM D 638
Elongation at Break	13	%	ASTM D 638
Flexural Modulus	2000	MPa	ASTM D 790
Flexural Strength	56	MPa	ASTM D 790
Rockwell Hardness	R 95	-	ASTM D 785
Izod Impact notched, 1/8 in	200	J/m	ASTM D 256
Izod Impact notched, 1/4 in	160	J/m	ASTM D 256
Thermal properties			
ISO Data	Value	Unit	Test Standard
Temp. of deflection under load, 1.80 MPa	72	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	84	°C	ISO 75-1/-2
Vicat softening temperature, B	90	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	2.0	mm	-
Burning behav. 5V at thickness h	5VA	class	IEC 60695-11-20
Thickness tested	3.0	mm	-
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	80	°C	ASTM D 648
Other properties			
Value	Unit	Test Standard	
Density	1160	kg/m ³	ISO 1183
Density	1160	kg/m ³	ASTM D 792

STAREX VE-0856 U

ABS

Lotte Chemical Corporation

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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	-
Injection pressure	49 - 150	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color