STAREX VE-0856

ABS — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**3.5**	g/10min	ISO 1133
Temperature	**200**	°C	-
Load	**5**	kg	-
Molding shrinkage, parallel	**0.3**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.3**	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	**3.5**	g/10min	ASTM D 1238
Temperature	**200**	°C	-
Load	**5**	kg	-
Mold Shrinkage, MD	**0.0045**	mm/mm	ASTM D 955
Mold Shrinkage, TD	**0.0045**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2010**	MPa	ISO 527
Yield stress	**43**	MPa	ISO 527
Stress at break	**31**	MPa	ISO 527
Strain at break	**3**	%	ISO 527
Flexural modulus, 23°C	**2240**	MPa	ISO 178
Flexural strength	**66**	MPa	ISO 178
Charpy notched impact strength, +23°C	**24**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**25**	kJ/m²	ISO 180/1A
Rockwell hardness	**R 96**	-	ISO 2039-2
ASTM Data			
Tensile Modulus	**1200**	MPa	ASTM D 638
Tensile Strength at Yield	**39**	MPa	ASTM D 638
Tensile Strength at Break	**26**	MPa	ASTM D 638
Elongation at Break	**18**	%	ASTM D 638
Flexural Modulus	**2000**	MPa	ASTM D 790
Flexural Strength	**53**	MPa	ASTM D 790
Rockwell Hardness	**R 96**	-	ASTM D 785
Izod Impact notched, 1/8 in	**180**	J/m	ASTM D 256
Izod Impact notched, 1/4 in	**170**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**75**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**87**	°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 @ 66 psi	**101**	°C	ASTM D 648
DTUL @ 264 psi	**80**	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	**1150**	kg/m³	ISO 1183
Density	**1150**	kg/m³	ASTM D 792

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Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**85**	°C	-
Pre-drying - Time	**2 - 4**	h	-
Processing humidity	**≤0.1**	%	-
Melt temperature	**210**	°C	-
Mold temperature	**40 - 70**	°C	-
Zone 1	**180 - 190**	°C	-
Zone 2	**200**	°C	-
Zone 3	**200 - 210**	°C	-
Nozzle temperature	**210**	°C	-
Screw speed	**60 - 90**	rpm	-
Injection pressure	**98**	MPa	-
Back pressure	**1 - 2.5**	MPa	-

Characteristics

Processing
Injection Molding

Regional Availability
North America, Europe, Asia Pacific

Delivery form
Pellets, Natural Color

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