

STAREX VE-0860 P

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	14	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	14	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0047	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.005	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Modulus	2240	MPa	ISO 527
Yield stress	43	MPa	ISO 527
Stress at break	32	MPa	ISO 527
Strain at break	4	%	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	70	MPa	ISO 178
Charpy notched impact strength, +23°C	24	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	23	kJ/m ²	ISO 180/1A
Rockwell hardness	R 97	-	ISO 2039-2
ASTM Data			
Tensile Modulus	1500	MPa	ASTM D 638
Tensile Strength at Yield	37	MPa	ASTM D 638
Tensile Strength at Break	22	MPa	ASTM D 638
Elongation at Break	9	%	ASTM D 638
Flexural Modulus	2000	MPa	ASTM D 790
Flexural Strength	55	MPa	ASTM D 790
Rockwell Hardness	R 102	-	ASTM D 785
Izod Impact notched, 1/8 in	150	J/m	ASTM D 256
Izod Impact notched, 1/4 in	140	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	80	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	92	°C	ISO 75-1/-2
Vicat softening temperature, B	99	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	V-2	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	5VB	class	IEC 60695-11-20
Thickness tested	2.5	mm	-
ASTM Data			
UL 94 Flame rating	V-2	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	89	°C	ASTM D 648
Other properties			
Density	1180	kg/m ³	ISO 1183
Density	1180	kg/m ³	ASTM D 792

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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	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color