

**STAREX VE-0860 T**

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	12	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	12	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0035	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0035	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
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 <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	23	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 97	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Modulus	1300	MPa	ASTM D 638
Tensile Strength at Yield	37	MPa	ASTM D 638
Tensile Strength at Break	29	MPa	ASTM D 638
Elongation at Break	17	%	ASTM D 638
Flexural Modulus	1900	MPa	ASTM D 790
Flexural Strength	54	MPa	ASTM D 790
Rockwell Hardness	R 97	-	ASTM D 785
Izod Impact notched, 1/8 in	330	J/m	ASTM D 256
Izod Impact notched, 1/4 in	270	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
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	94	°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	2.5	mm	-
Burning behav. 5V at thickness h	5VB	class	IEC 60695-11-20
Thickness tested	2.5	mm	-
<b>ASTM Data</b>			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 66 psi	92	°C	ASTM D 648
DTUL @ 264 psi	80	°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

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

### Delivery form

Pellets, Natural Color

### Special Characteristics

Flame retardant

### Applications

Electrical and Electronical

### Regional Availability

North America, Europe, Asia Pacific