

STAREX VH-0800 E

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	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	5	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.0026	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0029	mm/mm	ASTM D 955
Mechanical properties			
ISO Data	Value	Unit	Test Standard
Tensile Modulus	2500	MPa	ISO 527
Yield stress	45	MPa	ISO 527
Stress at break	36	MPa	ISO 527
Strain at break	8.4	%	ISO 527
Flexural modulus, 23°C	2600	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Charpy notched impact strength, +23°C	19	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	18	kJ/m ²	ISO 180/1A
Rockwell hardness	R 108	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2200	MPa	ASTM D 638
Tensile Strength at Yield	39	MPa	ASTM D 638
Tensile Strength at Break	32	MPa	ASTM D 638
Elongation at Break	16	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	59	MPa	ASTM D 790
Rockwell Hardness	R 103	-	ASTM D 785
Izod Impact notched, 1/8 in	200	J/m	ASTM D 256
Izod Impact notched, 1/4 in	200	J/m	ASTM D 256
Thermal properties			
ISO Data	Value	Unit	Test Standard
Temp. of deflection under load, 1.80 MPa	71	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	81	°C	ISO 75-1/-2
Vicat softening temperature, B	85	°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	3.0	mm	-
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	76	°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
Processing Recommendation Injection Molding			
Value	Unit	Test Standard	
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.05	%	-

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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

Applications

Electrical and Electronical

Regional Availability

North America, Europe, Asia Pacific