

STAREX VH-0810 M

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	4.5	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	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	4.5	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			
ISO Data			
Rockwell hardness	R 108	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2200	MPa	ASTM D 638
Tensile Strength at Yield	41	MPa	ASTM D 638
Tensile Strength at Break	33	MPa	ASTM D 638
Elongation at Break	15	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	62	MPa	ASTM D 790
Rockwell Hardness	R 105	-	ASTM D 785
Izod Impact notched, 1/8 in	240	J/m	ASTM D 256
Izod Impact notched, 1/4 in	220	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	70	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	85	°C	ISO 75-1/-2
Vicat softening temperature, B	85	°C	ISO 306
Burning behav. at thickness h	V-1	class	IEC 60695-11-10
Thickness tested	2.0	mm	-
ASTM Data			
UL 94 Flame rating	V-1	-	UL 94
Thickness tested	2	mm	-
DTUL @ 66 psi	85	°C	ASTM D 648
DTUL @ 264 psi	78	°C	ASTM D 648
Other properties			
Density	1150	kg/m ³	ISO 1183
Density	1150	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	230	°C	-
Mold temperature	50 - 70	°C	-
Zone 1	190 - 210	°C	-
Zone 2	210	°C	-
Zone 3	210 - 230	°C	-
Nozzle temperature	230	°C	-
Screw speed	40 - 50	rpm	-
Injection pressure	98	MPa	-
Back pressure	1 - 2.5	MPa	-

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Characteristics

Processing

Injection Molding

Delivery form

Pellets, Natural Color

Applications

Electrical and Electronical

Regional Availability

North America, Europe, Asia Pacific