STAREX VH-0815 M

ABS — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**4**	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	**3.8**	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	**2270**	MPa	ISO 527
Yield stress	**46**	MPa	ISO 527
Stress at break	**34**	MPa	ISO 527
Flexural modulus, 23°C	**3480**	MPa	ISO 178
Flexural strength	**73**	MPa	ISO 178
Charpy notched impact strength, +23°C	**20.4**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**18.6**	kJ/m²	ISO 180/1A
Rockwell hardness	**R 107,8**	-	ISO 2039-2
ASTM Data			
Tensile Modulus	**2100**	MPa	ASTM D 638
Tensile Strength at Yield	**41**	MPa	ASTM D 638
Tensile Strength at Break	**31**	MPa	ASTM D 638
Flexural Modulus	**2200**	MPa	ASTM D 790
Flexural Strength	**60**	MPa	ASTM D 790
Rockwell Hardness	**R 104,5**	-	ASTM D 785

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**70**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**86**	°C	ISO 75-1/-2
Vicat softening temperature, B	**85.7**	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	**V-1**	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	**2.5**	mm	-
ASTM Data			
UL 94 Flame rating	**V-1**	-	UL 94
Thickness tested	**1.5**	mm	-
DTUL @ 66 psi	**85**	°C	ASTM D 648
DTUL @ 264 psi	**78**	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	**1160**	kg/m³	ISO 1183
Density	**1160**	kg/m³	ASTM D 792

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	**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	-

Characteristics

Processing
Injection Molding

Applications
Electrical and Electronical

Delivery form
Pellets, Natural Color

Regional Availability
North America, Europe, Asia Pacific