

STAREX VH-0819

ABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	8.5	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	8	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.0055	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0055	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2300	MPa	ISO 527
Yield stress	48	MPa	ISO 527
Stress at break	30	MPa	ISO 527
Strain at break	7	%	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	72	MPa	ISO 178
Charpy notched impact strength, +23°C	13	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	13	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	41	MPa	ASTM D 638
Tensile Strength at Break	38	MPa	ASTM D 638
Elongation at Break	10	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	61	MPa	ASTM D 790
Rockwell Hardness	R 106	-	ASTM D 785
Izod Impact notched, 1/8 in	140	J/m	ASTM D 256
Izod Impact notched, 1/4 in	79	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	73	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	75	°C	ISO 75-1/-2
Vicat softening temperature, B	90	°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	-
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	2	mm	-
DTUL @ 66 psi	84	°C	ASTM D 648
DTUL @ 264 psi	80	°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	-

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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

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color