



Starex SR-0320 K			
ABS		Lotte Chemical Corporation	
Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index	9	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0055	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0055	mm/mm	ASTM D 955
Density	1060	kg/m³	ASTM D 792
Rheological properties	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
Melt flow index, MFI	9	g/10min	ISO 1133
MFI temperature	220	°C	-
MFI load	10	kg	-
Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	48	MPa	ISO 527
Strain at break	36	%	ISO 527
Charpy notched impact strength, +23°C	15	kJ/m²	ISO 179/1eA
Flexural modulus, 23°C	2450	MPa	ISO 178
Flexural strength	76	MPa	ISO 178
Izod Impact notched, 23°C	17	kJ/m²	ISO 180/1A
Rockwell hardness	R 110	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	41	MPa	ASTM D 638
Elongation at Break	35	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	64	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785
Izod Impact notched, 1/4 in	170	J/m	ASTM D 256
Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	86	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	100	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	106	°C	ISO 306
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	94	°C	ASTM D 648
Other properties	Value	Unit	Test Standard
ISO Data			
Water absorption	0.3	%	Sim. to ISO 62
Density	1060	kg/m³	ISO 1183
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	90 - 90	°C	-
Pre-drying - Time	3 - 4	h	-

ABS

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Processing humidity	≤0.1	%	-
Melt temperature	220 - 230	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	190 - 205	°C	-
Zone 2	205 - 225	°C	-
Zone 3	225 - 245	°C	-
Nozzle temperature	230 - 260	°C	-
Screw speed	50 - 150	rpm	-
Injection pressure	49 - 150	MPa	-
Back pressure	0.5 - 2	MPa	-

Processing

Injection Molding

Automotive, Electrical and Electronical

Pellets, Natural Color