



Starex WR-9330I			
ASA		Lotte Chemical Corporation	
Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index	5	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	1070	kg/m ³	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	5	g/10min	ISO 1133
MFI temperature	220	°C	-
MFI load	10	kg	-
Mechanical properties			
Value	Unit	Test Standard	
ISO Data			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	52	MPa	ISO 527
Strain at break	11	%	ISO 527
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Izod Impact notched, 23°C	9	kJ/m ²	ISO 180/1A
Rockwell hardness	R 108	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2100	MPa	ASTM D 638
Tensile Strength at Yield	47	MPa	ASTM D 638
Elongation at Break	17	%	ASTM D 638
Flexural Modulus	2300	MPa	ASTM D 790
Flexural Strength	70	MPa	ASTM D 790
Rockwell Hardness	R 107	-	ASTM D 785
Izod Impact notched, 1/8 in	140	J/m	ASTM D 256
Thermal properties			
Value	Unit	Test Standard	
ISO Data			
Temp. of deflection under load, 1.80 MPa	82	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	97	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	104	°C	ISO 306
Other properties			
Value	Unit	Test Standard	
ISO Data			
Density	1070	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Value	Unit	Test Standard	
Pre-drying - Temperature	75 - 85	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	230 - 260	°C	-
Mold temperature	50 - 70	°C	-

Starex WR-9330I

ASA

Lotte Chemical Corporation

Zone 1	190 - 205	°C	-
Zone 2	205 - 225	°C	-
Zone 3	225 - 245	°C	-
Nozzle temperature	245 - 245	°C	-
Screw speed	50 - 90	rpm	-
Injection pressure	98 - 98	MPa	-
Back pressure	1 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Special Characteristics

U.V. stabilized or stable to weather

Delivery form

Pellets, Natural Color

Applications

Automotive