

Starex VE-1870 U

High Impact Polystyrene

LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Starex VE-1870 U is a high impact polystyrene product. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific.
Features include:
flame retardant/rated flame
Flame Retardant

General Information			
UL YellowCard	E115797-219770		
Features	Flame retardancy		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	8.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	90		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	22.0	MPa	ASTM D638
Flexural Modulus ²	1800	MPa	ASTM D790
Flexural Strength ³	28.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	98	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	72.0	°C	ASTM D648
Vicat Softening Temperature	82.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.7 mm	V-0		UL 94
3.4 mm	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature			
--	60	°C	
Hot air dryer	60	°C	
Drying Time			
--	4.0 - 6.0	hr	
Hot air dryer	2.0 - 4.0	hr	
Suggested Max Moisture	< 0.10	%	
Rear Temperature	180 - 210	°C	

Middle Temperature	210	°C
Front Temperature	210	°C
Nozzle Temperature	220	°C
Mold Temperature	60 - 80	°C
Injection Pressure	68.6 - 206	MPa
Back Pressure	0.981	MPa
Screw Speed	40	rpm

Injection instructions

Hot Runner Manifold Temperature: 210°C Hot Runner Valve Nozzle Temperature: 210°C

NOTE

- | | |
|----|------------|
| 1. | 20 mm/min |
| 2. | 2.8 mm/min |
| 3. | 2.8 mm/min |

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