

Starex VE-1897

High Impact Polystyrene
LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Starex VE-1897 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	E115797-544032		
Features	Flame retardancy		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.15	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	16	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow: 3.20mm	0.30 - 0.40	%	ASTM D955
Transverse flow: 3.20mm	0.40 - 0.50	%	ASTM D955
Traffic: 3.20mm	0.30 - 0.40	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	100		ASTM D785
R scale	98		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2060	MPa	ASTM D638
--	2090	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	22.6	MPa	ASTM D638
Yield	23.0	MPa	ISO 527-2/50
Fracture ³	25.5	MPa	ASTM D638
Fracture	22.0	MPa	ISO 527-2/50
Tensile Elongation			
Fracture ⁴	35	%	ASTM D638
Fracture	35	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	1910	MPa	ASTM D790
-- ⁶	1600	MPa	ISO 178
Flexural Strength			
-- ⁷	31.4	MPa	ASTM D790
-- ⁸	37.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	12	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	93	J/m	ASTM D256
23°C, 6.35 mm	62	J/m	ASTM D256
23°C ¹⁰	11	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, unannealed, 4.00mm	81.0	°C	ISO 75-2/B
0.45 MPa, annealing, 4.00mm	84.0	°C	ISO 75-2/B
1.8 MPa, unannealed, 6.40mm	75.0	°C	ASTM D648
1.8 MPa, not annealed, 4.00mm	70.0	°C	ISO 75-2/A
1.8 MPa, annealing, 4.00mm	79.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	81.0	°C	ISO 306/B50
--	85.0	°C	ISO 306/B120
Flammability	Nominal Value	Test Method	
Flame Rating		UL 94	
1.5 mm	V-0	UL 94	
3.0 mm	V-0	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature			
--	60	°C	
Hot air dryer	60	°C	
Drying Time			
--	2.0 - 4.0	hr	
Hot air dryer	2.0 - 4.0	hr	
Suggested Max Moisture	0.050	%	
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.	20 mm/min		
3.	20 mm/min		

4.	20 mm/min
5.	2.8 mm/min
6.	2.0 mm/min
7.	2.8 mm/min
8.	2.0 mm/min
9.	Thickness: 4mm
10.	Thickness: 4mm

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