

Starex HG-0760GP

Acrylonitrile Butadiene Styrene
LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Starex HG-0760GP is an acrylonitrile butadiene styrene (ABS) product. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. Typical application areas are: electrical appliances.

General Information			
UL YellowCard	E115797-219542		
Features	General		
Uses	Electrical appliances		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	4.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow: 3.20mm	0.35 - 0.43	%	ASTM D955
Transverse flow: 3.20mm	0.37 - 0.45	%	ASTM D955
Lateral flow: 3.20mm	0.37 - 0.45	%	ISO 2577
Traffic: 3.20mm	0.35 - 0.43	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	108		ASTM D785
R scale	108		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2200	MPa	ASTM D638
--	2300	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	39.0	MPa	ASTM D638
Yield	40.0	MPa	ISO 527-2/50
Fracture ³	32.0	MPa	ASTM D638
Fracture	34.0	MPa	ISO 527-2/50
Tensile Elongation			
Fracture ⁴	24	%	ASTM D638
Fracture	21	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2000	MPa	ASTM D790
-- ⁶	2000	MPa	ISO 178
Flexural Strength			
-- ⁷	59.0	MPa	ASTM D790

-- ⁸	60.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	20	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	240	J/m	ASTM D256
23°C, 6.35 mm	230	J/m	ASTM D256
23°C ¹⁰	23	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, unannealed, 4.00mm	88.0	°C	ISO 75-2/B
0.45 MPa, annealing, 4.00mm	98.0	°C	ISO 75-2/B
1.8 MPa, unannealed, 6.40mm	82.0	°C	ASTM D648
1.8 MPa, not annealed, 4.00mm	76.0	°C	ISO 75-2/A
1.8 MPa, annealing, 4.00mm	93.0	°C	ISO 75-2/A
Vicat Softening Temperature	96.0	°C	ISO 306/B50
Injection	Nominal Value	Unit	
Drying Temperature			
--	80	°C	
Hot air dryer	80	°C	
Drying Time			
--	2.0 - 4.0	hr	
Hot air dryer	2.0 - 3.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	210 - 220	°C	
Middle Temperature	190 - 200	°C	
Front Temperature	160 - 180	°C	
Nozzle Temperature	230	°C	
Mold Temperature	40 - 80	°C	
Injection Pressure	49.0 - 147	MPa	
Back Pressure	0.490 - 1.96	MPa	
Screw Speed	50 - 150	rpm	
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	5.0 mm/min		
4.	5.0 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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