

Starex VH-0815

Acrylonitrile Butadiene Styrene
LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Starex VH-0815 is an acrylonitrile butadiene styrene (ABS) product. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. Starex VH-0815 applications include electrical/electronic applications and electrical appliances.

Features include:

- flame retardant/rated flame
- ROHS certification
- Flame Retardant

General Information			
UL YellowCard	E115797-219611		
Features	Flame retardancy		
Uses	Electrical/Electronic Applications		
	Electrical appliances		
RoHS Compliance	RoHS compliance		
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	3.8	g/10 min	ASTM D1238
200°C/5.0 kg	4.2	g/10 min	ISO 1133
Molding Shrinkage			
Flow: 3.20mm	0.34 - 0.41	%	ASTM D955
Transverse flow: 3.20mm	0.36 - 0.44	%	ASTM D955
Lateral flow: 3.20mm	0.36 - 0.44	%	ISO 2577
Traffic: 3.20mm	0.34 - 0.41	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	100		ASTM D785
R scale	104		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2000	MPa	ASTM D638
--	2200	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	39.0	MPa	ASTM D638
Yield	45.0	MPa	ISO 527-2/50
Fracture ³	27.0	MPa	ASTM D638
Fracture	33.0	MPa	ISO 527-2/50
Tensile Elongation			

Fracture ⁴	17	%	ASTM D638
Fracture	8.0	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2200	MPa	ASTM D790
-- ⁶	2400	MPa	ISO 178
Flexural Strength			
-- ⁷	59.0	MPa	ASTM D790
-- ⁸	71.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	22	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 6.35 mm	250	J/m	ASTM D256
23°C ¹⁰	19	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	77.0	°C	ASTM D648
1.8 MPa, not annealed, 4.00mm	71.0	°C	ISO 75-2/A
1.8 MPa, annealing, 4.00mm	79.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	86.0	°C	ISO 306/B50
--	88.0	°C	ISO 306/B120
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.5 mm	V-1	UL 94	
	V-0		
2.0 mm	5VB	UL 94	
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	160 - 180	°C	
Middle Temperature	190 - 200	°C	
Front Temperature	210 - 220	°C	
Nozzle Temperature	220	°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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

