

Starex LX-0760

Acrylonitrile Butadiene Styrene
LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Starex LX-0760 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			
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)	3.2	g/10 min	ASTM D1238, ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	107		ASTM D785
R scale	107		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2300	MPa	ASTM D638
--	2400	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	41.0	MPa	ASTM D638
Yield	45.0	MPa	ISO 527-2/50
Fracture ³	34.0	MPa	ASTM D638
Fracture	34.0	MPa	ISO 527-2/50
Tensile Elongation			
Fracture ⁴	21	%	ASTM D638
Fracture	15	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2100	MPa	ASTM D790
-- ⁶	2400	MPa	ISO 178
Flexural Strength			
-- ⁷	60.0	MPa	ASTM D790
-- ⁸	72.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	19	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	140	J/m	ASTM D256
23°C, 6.35 mm	140	J/m	ASTM D256

23°C ¹⁰	17	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 6.40mm	94.0	°C	ASTM D648
0.45 MPa, unannealed, 4.00mm	90.0	°C	ISO 75-2/B
0.45 MPa, annealing, 4.00mm	95.0	°C	ISO 75-2/B
1.8 MPa, unannealed, 6.40mm	85.0	°C	ASTM D648
1.8 MPa, not annealed, 4.00mm	77.0	°C	ISO 75-2/A
1.8 MPa, annealing, 4.00mm	90.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	96.0	°C	ISO 306/B50
--	100	°C	ISO 306/B120
Injection	Nominal Value	Unit	
Drying Temperature			
--	85 - 95	°C	
Hot air dryer	85 - 95	°C	
Drying Time			
--	2.0 - 4.0	hr	
Hot air dryer	2.0 - 4.0	hr	
Suggested Max Moisture	< 0.10	%	
Rear Temperature	180 - 200	°C	
Middle Temperature	200 - 210	°C	
Front Temperature	210 - 230	°C	
Nozzle Temperature	220 - 240	°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.	50 mm/min		
2.	50 mm/min		
3.	50 mm/min		
4.	50 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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