

ISO Property

starex [®]	Grade	WR-0790
	Resin Type	ABS

Super UV Resistant, Home Appliances

Item	Measuring Method	Condition	Unit	Value
Physical				
Specific Gravity	ISO 1183	Natural or representative color	-	1.06
Melt Flow Index	ISO 1133	220°C, 10kg	g/10min	30
Mold Shrinkage(MD)	ISO 294-4	Flow at 2mm(MD)	%	0.3-0.6
Mold Shrinkage(TD)	ISO 294-4	X-Flow at 2mm(TD)	%	0.3-0.6
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	45
Tensile Strain at break	ISO 527	50mm/min	%	-
Tensile Modulus	ISO 527	50mm/min	MPa	2300
Tensile Strength at break	ISO 527	50mm/min	MPa	-
Flexural Strength	ISO 178	2.8mm/min	MPa	70
Flexural Modulus	ISO 178	2.8mm/min	MPa	2200
Izod Impact Strength(notched)	ISO 180 1A	at 23°C, 4mm	kJ/m ²	18
Charpy Impact Strength(V-notched)	ISO 179 1eA	at 23°C, 4mm	kJ/m ²	20
Rockwell Hardness	ISO 2039-2	R-Scale	-	110
Thermal				
Heat Deflection Temperature(Unannealed)	ISO 75-2	1.8MPa, 4.0mm	°C	74
VICAT Softening Temperature	ISO 306	B/50	°C	93

1. The above figures are the representative values based on NP, which may vary from color to color, and can be used as a reference only for the purpose of selecting materials.
2. The above figures are basic guidelines for selecting materials; therefore, they are not regarded as the official specifications for materials involved, and cannot be used for the purpose of designing a mold.
3. The above values can be adjusted in accordance with processing conditions, and the specific change in value is allowed only within a limited range in which adjustment has no adverse or negative impact on the final product.

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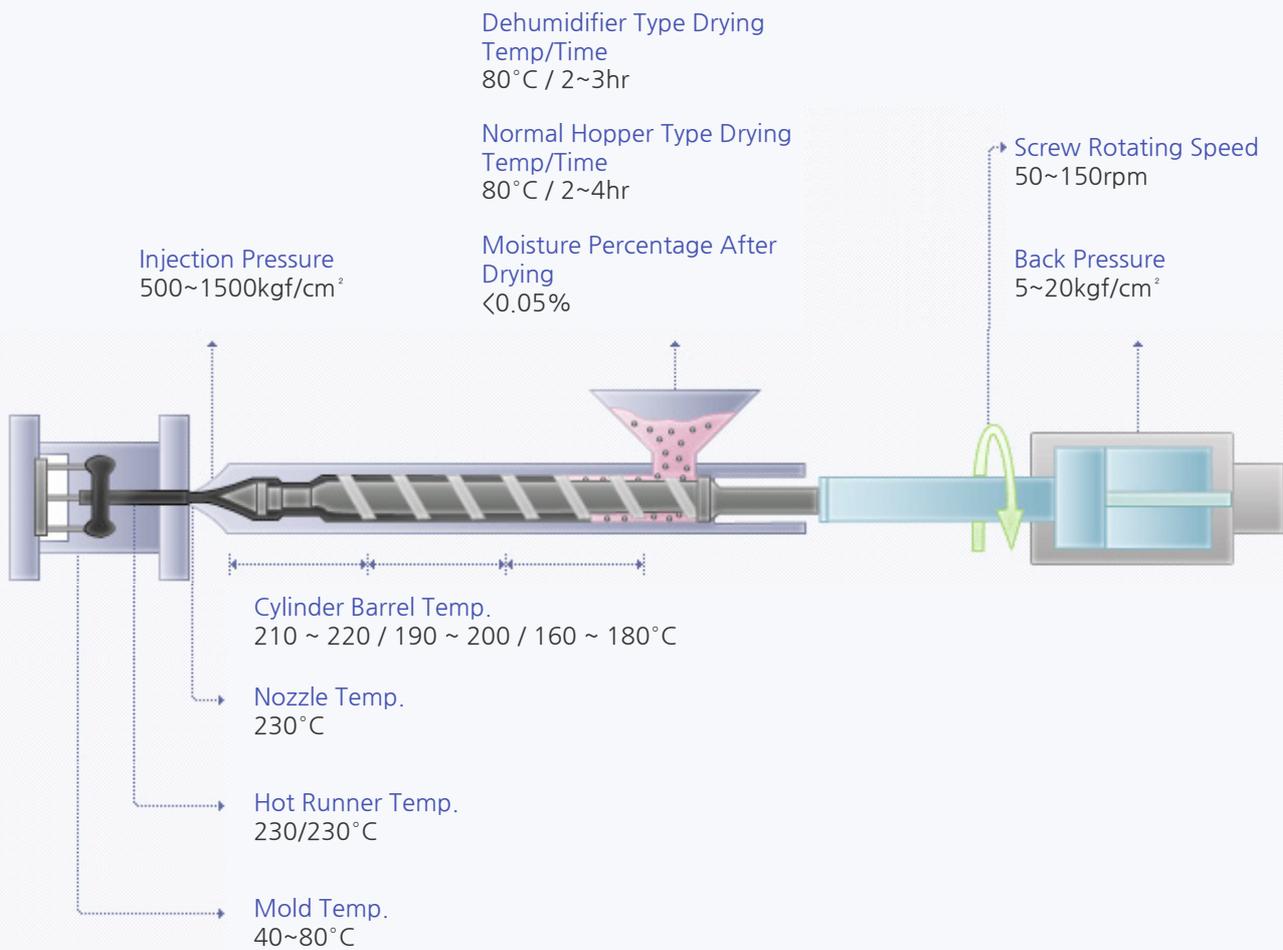
Whether materials and/or products of LOTTE Chemical and/or a design that uses or utilizes LOTTE Chemical' recommendations or proposals are (is) compatible with individual uses shall be determined solely by each user and such user shall be solely responsible for any results, including but not limited to, any and all loss and damages incurred due to such uses. Users must implement and verify all testing and analyses for proving the safety and compatibility of final products that have been created or altered by using LOTTE Chemical' materials or products. The data and values inserted and/or contained in this document may be changed due to quality improvement of the product without any prior notification.

※ The last update date : 02/14/2019

Processing Guide

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	Resin Type	ABS

Item		Unit	Representative	
Mold Temp. (Standard Molding)	Stationary Platen	°C	40 ~ 80	
	Moving Platen			
Hot Runner Temp.	Manifolder	°C	230	
	Valve Nozzle		230	
Nozzle Temp.		°C	230	
Cylinder Barrel Temp.	Front Part	°C	210 ~ 220	
	Mid Part	°C	190 ~ 200	
	Rear Part	°C	160 ~ 180	
Injection Pressure		kgf/cm ²	500~1500	
Drying Condition	Dehumidifier Type	Drying Temp	°C	80
		Drying Time	hr	2~3
	Normal Hopper Type	Drying Temp	°C	80
		Drying Time	hr	2~4
Moisture Percentage After Drying		%	<0.05	
Screw Rotating Speed		rpm	50 ~ 150	
Back Pressure		kgf/cm ²	5 ~ 20	



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