

Starex LH-0300

Acrylonitrile Butadiene Styrene
SAMSUNG SDI CO., LTD.

Message:

Starex LH-0300 is an Acrylonitrile Butadiene Styrene (ABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	10	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.42	%	
Across Flow : 3.20 mm	0.48	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1700	MPa	ASTM D638
--	1890	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	35.0	MPa	ASTM D638
Yield	36.0	MPa	ISO 527-2/50
Break ³	32.0	MPa	ASTM D638
Break	34.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	51	%	ASTM D638
Break	60	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	1700	MPa	ASTM D790
-- ⁶	2060	MPa	ISO 178
Flexural Strength			
-- ⁷	46.0	MPa	ASTM D790
-- ⁸	58.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	16	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	150	J/m	ASTM D256
23°C, 6.35 mm	98	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, 6.40 mm	99.0	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	94.0	°C	ISO 75-2/B
0.45 MPa, Annealed	103	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	88.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	80.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	100	°C	ISO 75-2/A
Vicat Softening Temperature	100	°C	ISO 306/B50
Injection	Nominal Value	Unit	
Drying Temperature			
--	120	°C	
Desiccant Dryer	120	°C	
Drying Time			
--	4.0 to 6.0	hr	
Desiccant Dryer	2.0 to 4.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	280 to 290	°C	
Middle Temperature	300 to 310	°C	
Front Temperature	320 to 330	°C	
Nozzle Temperature	330	°C	
Mold Temperature	100 to 140	°C	
Injection Pressure	108	MPa	
Back Pressure	0.490 to 1.96	MPa	
Screw Speed	50 to 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: 4 mm		
10.	Thickness: 4 mm		

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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

