

Starex VE-0860 P

Acrylonitrile Butadiene Styrene
LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Starex VE-0860 P 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.
Features include:
flame retardant/rated flame
Flame Retardant

General Information			
UL YellowCard	E115797-219595		
Features	Flame retardancy		
Uses	Electrical appliances		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.18	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	14	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow: 3.20mm	0.42 - 0.52	%	ASTM D955
Transverse flow: 3.20mm	0.45 - 0.55	%	ASTM D955
Lateral flow: 3.20mm	0.45 - 0.55	%	ISO 2577
Traffic: 3.20mm	0.42 - 0.52	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	102		ASTM D785
R scale	97		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1500	MPa	ASTM D638
--	2240	MPa	ISO 527-2/5
Tensile Strength			
Yield ²	37.0	MPa	ASTM D638
Yield	43.0	MPa	ISO 527-2/5
Fracture ³	22.0	MPa	ASTM D638
Fracture	32.0	MPa	ISO 527-2/5
Tensile Elongation			
Fracture ⁴	9.0	%	ASTM D638
Fracture	4.0	%	ISO 527-2/5
Flexural Modulus			
-- ⁵	2000	MPa	ASTM D790
-- ⁶	2300	MPa	ISO 178

Flexural Strength			
-- ⁷	55.0	MPa	ASTM D790
-- ⁸	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	24	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	150	J/m	ASTM D256
23°C, 6.35 mm	140	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	92.0	°C	ISO 75-2/B
0.45 MPa, annealing, 4.00mm	104	°C	ISO 75-2/B
1.8 MPa, unannealed, 6.40mm	89.0	°C	ASTM D648
1.8 MPa, not annealed, 4.00mm	80.0	°C	ISO 75-2/A
1.8 MPa, annealing, 4.00mm	100	°C	ISO 75-2/A
Vicat Softening Temperature	99.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.5 mm	V-2		UL 94
	V-2		
2.5 to 2.7mm	5VB		UL 94
2.0 mm	V-0		UL 94
Optical	Nominal Value	Unit	Test Method
Yellowness Index			ASTM D1925
--	15	YI	ASTM D1925
3.20 mm	15	YI	ASTM D1925
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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