

Starex TX-0520

Methyl Methacrylate / ABS

SAMSUNG SDI CO., LTD.

Message:

Starex TX-0520 is an Acrylonitrile Butadiene Styrene (ABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Primary characteristic: flame rated.

General Information			
UL YellowCard	E115797-101048866		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	15	g/10 min	ASTM D1238, ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	106		ASTM D785
R-Scale	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield ¹	42.0	MPa	ASTM D638
Yield	47.0	MPa	ISO 527-2/50
Flexural Modulus			
-- ²	2000	MPa	ASTM D790
-- ³	2200	MPa	ISO 178
Flexural Strength			
-- ⁴	59.0	MPa	ASTM D790
-- ⁵	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶ (23°C)	12	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	160	J/m	ASTM D256
23°C ⁷	12	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	87.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	HB		
3.00 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature			
--	80.0	°C	

Desiccant Dryer	80.0	°C
Drying Time		
--	4.0 to 6.0	hr
Desiccant Dryer	2.0 to 4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	180 to 190	°C
Middle Temperature	200 to 210	°C
Front Temperature	220 to 230	°C
Nozzle Temperature	230	°C
Mold Temperature	50.0 to 70.0	°C
Injection Pressure	49.0 to 196	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	50 to 150	rpm

NOTE

- | | |
|----|-----------------|
| 1. | 5.0 mm/min |
| 2. | 2.8 mm/min |
| 3. | 2.0 mm/min |
| 4. | 2.8 mm/min |
| 5. | 2.0 mm/min |
| 6. | Thickness: 4 mm |
| 7. | Thickness: 4 mm |

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