

Starex MP-0670

Acrylonitrile Butadiene Styrene
SAMSUNG SDI CO., LTD.

Message:

Starex MP-0670 is an Acrylonitrile Butadiene Styrene (ABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Typical application: Automotive.

General Information			
UL YellowCard	E115797-604342		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	2.3	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow : 3.20 mm	0.50 to 0.60	%	ASTM D955
Across Flow	0.60 to 3.2	%	ASTM D955
Flow : 3.20 mm	0.50	%	ISO 2577
Water Absorption			
23°C, 24 hr	0.30	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	106		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2100	MPa	ASTM D638
--	2350	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	44.0	MPa	ASTM D638
Yield	51.0	MPa	ISO 527-2/50
Break ³	35.0	MPa	ASTM D638
Break	37.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	25	%	ASTM D638
Break	3.0	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2100	MPa	ASTM D790
-- ⁶	2350	MPa	ISO 178
Flexural Strength			
-- ⁷	65.0	MPa	ASTM D790
-- ⁸	72.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength ⁹ (23°C)	25	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C, 3.18 mm	88	J/m	ASTM D256
-30°C, 6.35 mm	79	J/m	ASTM D256
23°C, 3.18 mm	280	J/m	ASTM D256
23°C, 6.35 mm	270	J/m	ASTM D256
-30°C ¹⁰	8.0	kJ/m ²	ISO 180/1A
23°C ¹¹	25	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 4.00 mm	93.0	°C	ISO 75-2/B
0.45 MPa, Annealed	100	°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	96.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	100	°C	ISO 306/B50
--	101	°C	ISO 306/B120
Injection	Nominal Value	Unit	
Drying Temperature			
--	80.0	°C	
Desiccant Dryer	80.0	°C	
Drying Time			
--	2.0 to 4.0	hr	
Desiccant Dryer	2.0 to 3.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	160 to 180	°C	
Middle Temperature	190 to 200	°C	
Front Temperature	210 to 220	°C	
Nozzle Temperature	230	°C	
Mold Temperature	40.0 to 80.0	°C	
Injection Pressure	49.0 to 147	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
11.	Thickness: 4 mm

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