

Starex VG-4920F

Acrylonitrile Butadiene Styrene

SAMSUNG SDI CO., LTD.

Message:

Starex VG-4920F is an Acrylonitrile Butadiene Styrene (ABS) product filled with glass fiber. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Primary characteristic: flame rated.

General Information			
UL YellowCard	E115797-219600		
Filler / Reinforcement	Glass Fiber		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.33	g/cm ³	ASTM D792
--	1.34	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
220°C/10.0 kg	42	g/10 min	ASTM D1238
220°C/10.0 kg	41	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.10 to 0.30	%	ASTM D955
Ash Content	20	%	ISO 3451
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	110		ASTM D785
R-Scale	116		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5900	MPa	ASTM D638
--	6100	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	85.0	MPa	ASTM D638
Yield	102	MPa	ISO 527-2/50
Break ³	98.0	MPa	ASTM D638
Break	101	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	2.8	%	ASTM D638
Break	2.4	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	5700	MPa	ASTM D790
-- ⁶	7100	MPa	ISO 178
Flexural Strength			
-- ⁷	100	MPa	ASTM D790

-- ⁸	146	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	9.2	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	59	J/m	ASTM D256
23°C, 6.35 mm	60	J/m	ASTM D256
23°C ¹⁰	9.1	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	100	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	100	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	93.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	95.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	102	°C	ISO 306/B50
--	104	°C	ISO 306/B120
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.60 mm	V-0		
	V-0		
2.00 mm	5VA		
	V-0		
3.00 mm	5VA		
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	180 to 190	°C	
Middle Temperature	200 to 210	°C	
Front Temperature	220 to 230	°C	
Nozzle Temperature	240	°C	
Mold Temperature	40.0 to 80.0	°C	
Injection Pressure	49.0 to 245	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.	25 mm/min	
9.	Thickness: 4 mm	
10.	Thickness: 4 mm	

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