

Starex SF-0505HWR

Methyl Methacrylate / ABS

SAMSUNG SDI CO., LTD.

Message:

Starex SF-0505HWR is a Methyl Methacrylate / ABS (MABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Primary characteristic: flame rated.

General Information			
UL YellowCard	E115797-460972		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	19	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.30 to 0.60	%	ASTM D955, ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	109		ASTM D785
R-Scale	111		ISO 2039-2
Pencil Hardness ¹	HB		JIS K5401
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	2100	MPa	ASTM D638
--	2200	MPa	ISO 527-2/50
Tensile Strength			
Yield ³	43.0	MPa	ASTM D638
Yield	44.0	MPa	ISO 527-2/50
Break ⁴	32.0	MPa	ASTM D638
Break	35.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁵	21	%	ASTM D638
Break	12	%	ISO 527-2/50
Flexural Modulus			
-- ⁶	2100	MPa	ASTM D790
-- ⁷	2000	MPa	ISO 178
Flexural Strength			
-- ⁸	64.0	MPa	ASTM D790
-- ⁹	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹⁰ (23°C)	12	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	140	J/m	ASTM D256

23°C, 6.35 mm	120	J/m	ASTM D256
23°C ¹¹	12	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	87.0	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	82.0	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	83.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	71.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	90.0	°C	ISO 306/B50
--	92.0	°C	ISO 306/B120
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	HB		
3.00 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature			
--	85.0	°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	190 to 200	°C	
Middle Temperature	210 to 220	°C	
Front Temperature	230 to 240	°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.	Condition: 500g		
2.	5.0 mm/min		
3.	5.0 mm/min		
4.	5.0 mm/min		
5.	5.0 mm/min		
6.	2.8 mm/min		
7.	2.0 mm/min		
8.	2.8 mm/min		
9.	2.0 mm/min		
10.	Thickness: 4 mm		

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