

Starex SP-0183

Acrylonitrile Butadiene Styrene
SAMSUNG SDI CO., LTD.

Message:

Starex SP-0183 is an Acrylonitrile Butadiene Styrene (ABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	3.9	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.41 to 0.50	%	
Across Flow : 3.20 mm	0.47 to 0.58	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1900	MPa	ASTM D638
--	2000	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	41.0	MPa	ASTM D638
Yield	42.0	MPa	ISO 527-2/50
Break ³	33.0	MPa	ASTM D638
Break	40.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	50	%	ASTM D638
Break	14	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2000	MPa	ASTM D790
-- ⁶	2000	MPa	ISO 178
Flexural Strength			
-- ⁷	63.0	MPa	ASTM D790
-- ⁸	64.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C, 6.35 mm	400	J/m	ASTM D256
23°C ⁹	40	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			

0.45 MPa, Unannealed, 4.00 mm	94.0	°C	ISO 75-2/B
0.45 MPa, Annealed	102	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	91.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	81.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	100	°C	ISO 75-2/A
Vicat Softening Temperature	101	°C	ISO 306/B50

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	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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