

Starex BF-0930

Methyl Methacrylate / ABS

SAMSUNG SDI CO., LTD.

Message:

Starex BF-0930 is a Methyl Methacrylate / ABS (MABS) 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	1.13	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	33	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.35 to 0.43	%	
Across Flow : 3.20 mm	0.36 to 0.45	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	118		ASTM D785
R-Scale	121		ISO 2039-2
Pencil Hardness ¹	2H		JIS K5401
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	2600	MPa	ASTM D638
--	2900	MPa	ISO 527-2/50
Tensile Strength			
Yield ³	57.0	MPa	ASTM D638
Yield	73.0	MPa	ISO 527-2/50
Break ⁴	41.0	MPa	ASTM D638
Break	72.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁵	19	%	ASTM D638
Break	5.0	%	ISO 527-2/50
Flexural Modulus			
-- ⁶	2600	MPa	ASTM D790
-- ⁷	3000	MPa	ISO 178
Flexural Strength			
-- ⁸	87.0	MPa	ASTM D790
-- ⁹	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹⁰ (23°C)	2.0	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength ¹¹ (23°C)	25	kJ/m ²	ISO 179/1eU
Notched Izod Impact			
23°C, 3.18 mm	20	J/m	ASTM D256
23°C, 6.35 mm	20	J/m	ASTM D256
23°C ¹²	2.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C, 3.18 mm	250	J/m	ASTM D256
23°C, 6.35 mm	230	J/m	ASTM D256
23°C ¹³	25	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	89.0	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	87.0	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	79.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	76.0	°C	ISO 75-2/A
Vicat Softening Temperature	94.0	°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	190 to 200	°C	
Middle Temperature	210 to 220	°C	
Front Temperature	230 to 240	°C	
Nozzle Temperature	230	°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
11.	Thickness: 4 mm
12.	Thickness: 4 mm
13.	Thickness: 4 mm

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