

Starex GC-0710

Acrylonitrile Butadiene Styrene + PET

SAMSUNG SDI CO., LTD.

Message:

Starex GC-0710 is an Acrylonitrile Butadiene Styrene + PET (ABS+PET) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Primary characteristic: flame rated.

General Information			
UL YellowCard	E115797-100121015		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.44 to 0.54	%	
Across Flow : 3.20 mm	0.47 to 0.57	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	96		ASTM D785
R-Scale	100		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1710	MPa	ASTM D638
--	2000	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	40.2	MPa	ASTM D638
Yield	40.0	MPa	ISO 527-2/50
Break	35.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ³	40	%	ASTM D638
Break	7.0	%	ISO 527-2/50
Flexural Modulus			
-- ⁴	1870	MPa	ASTM D790
-- ⁵	1900	MPa	ISO 178
Flexural Strength			
-- ⁶	60.8	MPa	ASTM D790
-- ⁷	60.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁸ (23°C)	5.2	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	270	J/m	ASTM D256
23°C, 6.35 mm	120	J/m	ASTM D256

23°C ⁹	5.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 4.00 mm	83.0	°C	ISO 75-2/B
0.45 MPa, Annealed	96.0	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	80.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	70.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	85.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	94.0	°C	ISO 306/B50
--	97.0	°C	ISO 306/B120
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	HB		
3.00 mm	HB		
Optical	Nominal Value	Unit	Test Method
Yellowness Index (3.20 mm)	25	YI	ASTM D1925
Injection	Nominal Value	Unit	
Drying Temperature			
--	100	°C	
Desiccant Dryer	100	°C	
Drying Time			
--	2.0 to 4.0	hr	
Desiccant Dryer	2.0 to 3.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	220 to 230	°C	
Middle Temperature	230 to 240	°C	
Front Temperature	240 to 250	°C	
Nozzle Temperature	245	°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.	50 mm/min		
2.	50 mm/min		
3.	50 mm/min		
4.	2.8 mm/min		
5.	2.0 mm/min		
6.	2.8 mm/min		
7.	2.0 mm/min		
8.	Thickness: 4 mm		

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