

Starex VE-0813

Acrylonitrile Butadiene Styrene

SAMSUNG SDI CO., LTD.

Message:

Starex VE-0813 is an Acrylonitrile Butadiene Styrene (ABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Primary characteristic: flame rated.

General Information			
UL YellowCard	E115797-300767		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	6.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.30 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	99		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield ¹	35.0	MPa	ASTM D638
Yield	35.0	MPa	ISO 527-2/50
Flexural Modulus			
-- ²	2000	MPa	ASTM D790
-- ³	1950	MPa	ISO 178
Flexural Strength			
-- ⁴	51.0	MPa	ASTM D790
-- ⁵	50.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶ (23°C)	11	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 6.35 mm	98	J/m	ASTM D256
23°C ⁷	11	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 6.40 mm	76.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	76.0	°C	ISO 75-2/A
Vicat Softening Temperature	89.0	°C	ISO 306/B50
Flammability	Nominal Value	Test Method	
Flame Rating (2.00 mm)	V-0	UL 94	
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	220	°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. | 2.8 mm/min |
| 3. | 2.0 mm/min |
| 4. | 2.8 mm/min |
| 5. | 2.0 mm/min |
| 6. | Thickness: 4 mm |
| 7. | Thickness: 4 mm |

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