

Starex BF-0950

Methyl Methacrylate / ABS
LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Starex BF-0950 is a methyl methacrylate/ABS (MABS) product. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. Typical application areas are: electrical/electronic applications. The main characteristics are: flame retardant/rated flame.

General Information			
UL YellowCard	E115797-100500722		
Features	General		
Uses	Electrical/Electronic Applications		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.11	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	13	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow: 3.20mm	0.35 - 0.43	%	ASTM D955
Transverse flow: 3.20mm	0.37 - 0.45	%	ASTM D955
Lateral flow: 3.20mm	0.37 - 0.45	%	ISO 2577
Traffic: 3.20mm	0.35 - 0.43	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	116		ASTM D785
R scale	116		ISO 2039-2
Pencil Hardness ¹	H		JIS K5401
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	2500	MPa	ASTM D638
--	2600	MPa	ISO 527-2/50
Tensile Strength			
Yield ³	51.0	MPa	ASTM D638
Yield	55.0	MPa	ISO 527-2/50
Fracture ⁴	34.0	MPa	ASTM D638
Fracture	40.0	MPa	ISO 527-2/50
Tensile Elongation			
Fracture ⁵	25	%	ASTM D638
Fracture	20	%	ISO 527-2/50
Flexural Modulus			
-- ⁶	2600	MPa	ASTM D790
-- ⁷	2800	MPa	ISO 178
Flexural Strength			

-- 8	74.0	MPa	ASTM D790
-- 9	85.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹⁰ (23°C)	8.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	110	J/m	ASTM D256
23°C, 6.35 mm	98	J/m	ASTM D256
23°C ¹¹	7.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 6.40mm	98.0	°C	ASTM D648
0.45 MPa, unannealed, 4.00mm	91.0	°C	ISO 75-2/B
1.8 MPa, unannealed, 6.40mm	92.0	°C	ASTM D648
1.8 MPa, not annealed, 4.00mm	78.0	°C	ISO 75-2/A
Vicat Softening Temperature	100	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating (1.5 to 3.0mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature			
--	85	°C	
Hot air dryer	80	°C	
Drying Time			
--	4.0	hr	
Hot air dryer	4.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	200 - 220	°C	
Middle Temperature	220 - 240	°C	
Front Temperature	220 - 240	°C	
Nozzle Temperature	240	°C	
Mold Temperature	40 - 80	°C	
Injection Pressure	73.5 - 235	MPa	
Back Pressure	0.490	MPa	
Screw Speed	30	rpm	
Injection instructions			
Hot Runner Manifold Temperature: 240°C Hot Runner Valve Nozzle Temperature: 240°C			
NOTE			
1.	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: 4mm
11.	Thickness: 4mm

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