

Starex BF-0370

Methyl Methacrylate / ABS

SAMSUNG SDI CO., LTD.

Message:

Scratch resistant material that is applied to the exterior material of electric products and household appliances

General Information			
UL YellowCard	E115797-100648142		
Features	High Scratch Resistance		
Uses	Electrical Housing		
	Household Goods		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	15	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955
Flow : 3.20 mm	0.30 to 0.60	%	
Across Flow : 3.20 mm	0.27 to 0.33	%	

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	113		ASTM D785
R-Scale	115		ISO 2039-2
Pencil Hardness ¹	HB		JIS K5401

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	44.0	MPa	ASTM D638
Yield	45.0	MPa	ISO 527-2/50
Break	48.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ³	25	%	ASTM D638
Break	10	%	ISO 527-2/50
Flexural Modulus			
-- ⁴	2500	MPa	ASTM D790
-- ⁵	2700	MPa	ISO 178
Flexural Strength			
-- ⁶	74.0	MPa	ASTM D790
-- ⁷	90.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
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Charpy Notched Impact Strength ⁸ (23°C)	16	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	150	J/m	ASTM D256
23°C, 6.35 mm	130	J/m	ASTM D256
23°C ⁹	11	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 4.00 mm	96.0	°C	ISO 75-2/B
0.45 MPa, Annealed	104	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	89.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	84.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	101	°C	ISO 75-2/A
Vicat Softening Temperature			
--	102	°C	ISO 306/B50
--	104	°C	ISO 306/B120
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.00 mm	HB		
1.50 mm	HB		
3.00 mm	HB		
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: 1000g		
2.	5.0 mm/min		
3.	5.0 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
9.	Thickness: 4 mm

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