

Starex MG-0330

Acrylonitrile Butadiene Styrene
SAMSUNG SDI CO., LTD.

Message:

Starex MG-0330 is an Acrylonitrile Butadiene Styrene (ABS) 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			
--	1.04	g/cm ³	ASTM D792
--	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	3.5	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.50 to 0.60	%	
Across Flow : 3.20 mm	0.60	%	
Water Absorption			
23°C, 24 hr	0.30	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	111		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield ¹	43.0	MPa	ASTM D638
Yield	45.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ²	15	%	ASTM D638
Break	15	%	ISO 527-2/50
Flexural Modulus			
-- ³	2200	MPa	ASTM D790
-- ⁴	2400	MPa	ISO 178
Flexural Strength			
-- ⁵	62.0	MPa	ASTM D790
-- ⁶	78.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁷ (23°C)	14	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 6.35 mm	140	J/m	ASTM D256
23°C ⁸	14	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature			
0.45 MPa, Unannealed, 4.00 mm	109	°C	ISO 75-2/B
0.45 MPa, Annealed	123	°C	ISO 75-2/B
1.8 MPa, Unannealed, 4.00 mm	93.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	106	°C	ISO 75-2/A
Vicat Softening Temperature	116	°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	160 to 180	°C
Middle Temperature	190 to 200	°C
Front Temperature	210 to 220	°C
Nozzle Temperature	230	°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.	5.0 mm/min
3.	2.8 mm/min
4.	2.0 mm/min
5.	2.8 mm/min
6.	2.0 mm/min
7.	Thickness: 4 mm
8.	Thickness: 4 mm

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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