

Starex HF-0680

Acrylonitrile Butadiene Styrene
LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Starex HF-0680 is an acrylonitrile butadiene styrene (ABS) product. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The main characteristics are: flame retardant/rated flame.

General Information			
UL YellowCard	E115797-219539		
Features	General		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.5	g/10 min	ASTM D1238, ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	107		ASTM D785
R scale	107		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield ¹	41.0	MPa	ASTM D638
Yield	40.0	MPa	ISO 527-2/50
Flexural Modulus			
-- ²	2100	MPa	ASTM D790
-- ³	1900	MPa	ISO 178
Flexural Strength			
-- ⁴	62.0	MPa	ASTM D790
-- ⁵	60.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶ (23°C)	18	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 6.35 mm	200	J/m	ASTM D256
23°C ⁷	20	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	85.0	°C	ASTM D648
Vicat Softening Temperature	97.0	°C	ISO 306/B50
Flammability	Nominal Value	Test Method	
Flame Rating (1.5 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature			
--	80	°C	

Hot air dryer	80	°C
Drying Time		
--	2.0 - 4.0	hr
Hot air dryer	2.0 - 3.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	210 - 220	°C
Middle Temperature	190 - 200	°C
Front Temperature	160 - 180	°C
Nozzle Temperature	230	°C
Mold Temperature	40 - 80	°C
Injection Pressure	49.0 - 147	MPa
Back Pressure	0.490 - 1.96	MPa
Screw Speed	50 - 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: 4mm |
| 7. | Thickness: 4mm |

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