

# Starex VE-0860EX

Acrylonitrile Butadiene Styrene

SAMSUNG SDI CO., LTD.

Message:

Starex VE-0860EX 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                                      | E115797-219595 |                   |                       |
| Physical                                           | Nominal Value  | Unit              | Test Method           |
| Specific Gravity                                   | 1.18           | g/cm <sup>3</sup> | ASTM D792, ISO 1183   |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)          | 16             | g/10 min          | ASTM D1238, ISO 1133  |
| Molding Shrinkage - Flow (3.20 mm)                 | 0.30 to 0.60   | %                 | ASTM D955, ISO 2577   |
| Hardness                                           | Nominal Value  | Unit              | Test Method           |
| Rockwell Hardness (R-Scale)                        | 98             |                   | ASTM D785, ISO 2039-2 |
| Mechanical                                         | Nominal Value  | Unit              | Test Method           |
| Tensile Modulus                                    | 2200           | MPa               | ISO 527-2/50          |
| Tensile Strength                                   |                |                   |                       |
| Yield <sup>1</sup>                                 | 43.0           | MPa               | ASTM D638             |
| Yield                                              | 47.0           | MPa               | ISO 527-2/50          |
| Break                                              | 35.0           | MPa               | ISO 527-2/50          |
| Tensile Strain (Break)                             | 8.0            | %                 | ISO 527-2/50          |
| Flexural Modulus                                   |                |                   |                       |
| -- <sup>2</sup>                                    | 2100           | MPa               | ASTM D790             |
| -- <sup>3</sup>                                    | 2300           | MPa               | ISO 178               |
| Flexural Strength                                  |                |                   |                       |
| -- <sup>4</sup>                                    | 59.0           | MPa               | ASTM D790             |
| -- <sup>5</sup>                                    | 72.0           | MPa               | ISO 178               |
| Impact                                             | Nominal Value  | Unit              | Test Method           |
| Charpy Notched Impact Strength <sup>6</sup> (23°C) | 23             | kJ/m <sup>2</sup> | ISO 179/1eA           |
| Notched Izod Impact                                |                |                   |                       |
| 23°C, 6.35 mm                                      | 200            | J/m               | ASTM D256             |
| 23°C <sup>7</sup>                                  | 25             | kJ/m <sup>2</sup> | ISO 180/1A            |
| Thermal                                            | Nominal Value  | Unit              | Test Method           |
| Heat Deflection Temperature                        |                |                   |                       |
| 0.45 MPa, Unannealed, 4.00 mm                      | 90.0           | °C                | ISO 75-2/B            |
| 0.45 MPa, Annealed                                 | 91.0           | °C                | ISO 75-2/B            |
| 1.8 MPa, Unannealed, 6.40 mm                       | 82.0           | °C                | ASTM D648             |
| 1.8 MPa, Unannealed, 4.00 mm                       | 78.0           | °C                | ISO 75-2/A            |
| 1.8 MPa, Annealed, 4.00 mm                         | 84.0           | °C                | ISO 75-2/A            |

|                             |                 |      |              |
|-----------------------------|-----------------|------|--------------|
| Vicat Softening Temperature |                 |      |              |
| --                          | 94.0            | °C   | ISO 306/B50  |
| --                          | 97.0            | °C   | ISO 306/B120 |
| Flammability                | Nominal Value   |      | Test Method  |
| Flame Rating                |                 |      | UL 94        |
| 1.50 mm                     | V-0             |      |              |
|                             | V-0             |      |              |
| 2.50 to 2.70 mm             | 5VB             |      |              |
| 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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