

Starex ES-0173

Acrylonitrile Butadiene Styrene
SAMSUNG SDI CO., LTD.

Message:
Extrusion ABS for the interior of refrigerator with HCFC-141b, down gauging characteristic

General Information			
UL YellowCard	E115797-219532		
Uses	Household Goods		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	3.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	92		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1900	MPa	ISO 527-2/50
Tensile Strength			
Yield ¹	39.0	MPa	ASTM D638
Yield	41.0	MPa	ISO 527-2/50
Break	33.0	MPa	ISO 527-2/50
Tensile Strain (Break)	22	%	ISO 527-2/50
Flexural Modulus			
-- ²	1900	MPa	ASTM D790
-- ³	2000	MPa	ISO 178
Flexural Strength			
-- ⁴	52.0	MPa	ASTM D790
-- ⁵	55.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶ (23°C)	42	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 6.35 mm	350	J/m	ASTM D256
23°C ⁷	45	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 4.00 mm	94.0	°C	ISO 75-2/B
0.45 MPa, Annealed	101	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	89.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	80.0	°C	ISO 75-2/A

1.8 MPa, Annealed, 4.00 mm	95.0	°C	ISO 75-2/A
Vicat Softening Temperature	99.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating (1.30 to 1.40 mm)	HB		UL 94
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	14.7 to 49.0	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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