

Starex HF-0660I

Acrylonitrile Butadiene Styrene

SAMSUNG SDI CO., LTD.

Message:

Material with the characteristic of high flowability and high stiffness that can be used for vacuum cleaner, telephone, TV, VCR, calculator, radio and air-conditioner

General Information	
UL YellowCard	E115797-219537
Features	High Flow
	High Stiffness
Uses	Electrical/Electronic Applications
	Household Goods

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	3.6	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955, ISO 294-4
Flow : 3.20 mm	0.30	%	
Across Flow : 3.20 mm	0.30	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2200	MPa	ASTM D638
--	2300	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	39.0	MPa	ASTM D638
Yield	40.0	MPa	ISO 527-2/50
Break ³	39.0	MPa	ASTM D638
Break	33.0	MPa	ISO 527-2/50
Tensile Strain (Break)	13	%	ISO 527-2/50
Flexural Modulus			
-- ⁴	2000	MPa	ASTM D790
-- ⁵	2000	MPa	ISO 178
Flexural Strength			
-- ⁶	59.0	MPa	ASTM D790
-- ⁷	60.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength ⁸ (23°C)	21	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	260	J/m	ASTM D256
23°C, 6.35 mm	220	J/m	ASTM D256
23°C ⁹	22	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	93.0	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	86.0	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	85.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	74.0	°C	ISO 75-2/A
Vicat Softening Temperature	96.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.00 mm	HB		
1.50 mm	HB		
3.00 mm	HB		
6.00 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	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.	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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