

Starex TX-0520T

Methyl Methacrylate / ABS

SAMSUNG SDI CO., LTD.

Message:

Starex TX-0520T 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		E115797-101048866	
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	15	g/10 min	ASTM D1238, ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	106		ASTM D785
R-Scale	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2100	MPa	ISO 527-2/50
Tensile Strength			
Yield ¹	42.0	MPa	ASTM D638
Yield	47.0	MPa	ISO 527-2/50
Break	34.0	MPa	ISO 527-2/50
Tensile Strain (Break)	15	%	ISO 527-2/50
Flexural Modulus			
-- ²	2000	MPa	ASTM D790
-- ³	2200	MPa	ISO 178
Flexural Strength			
-- ⁴	59.0	MPa	ASTM D790
-- ⁵	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶ (23°C)	12	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	160	J/m	ASTM D256
23°C ⁷	12	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 4.00 mm	81.0	°C	ISO 75-2/B
0.45 MPa, Annealed	85.0	°C	ISO 75-2/B
1.8 MPa, Unannealed, 4.00 mm	71.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	80.0	°C	ISO 75-2/A

Vicat Softening Temperature	87.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	HB		
3.00 mm	HB		
Optical	Nominal Value	Unit	Test Method
Transmittance (3200 μm)	88.0	%	ASTM D1003
Haze (3200 μm)	3.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature			
--	80.0	°C	
Desiccant Dryer	80.0	°C	
Drying Time			
--	4.0 to 6.0	hr	
Desiccant Dryer	2.0 to 4.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	180 to 190	°C	
Middle Temperature	200 to 210	°C	
Front Temperature	220 to 230	°C	
Nozzle Temperature	230	°C	
Mold Temperature	50.0 to 70.0	°C	
Injection Pressure	49.0 to 196	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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