

Starex SF-0941

Methyl Methacrylate / ABS

SAMSUNG SDI CO., LTD.

Message:

Starex SF-0941 is a Methyl Methacrylate / ABS (MABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.16	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	26	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	ASTM D955, ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2700	MPa	ISO 527-2/50
Tensile Strength			
Yield ¹	69.0	MPa	ASTM D638
Yield	64.0	MPa	ISO 527-2/50
Break	51.0	MPa	ISO 527-2/50
Tensile Strain (Break)	15	%	ISO 527-2/50
Flexural Modulus			
-- ²	2500	MPa	ASTM D790
-- ³	2500	MPa	ISO 178
Flexural Strength			
-- ⁴	81.0	MPa	ASTM D790
-- ⁵	89.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶ (23°C)	7.9	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	59	J/m	ASTM D256
23°C ⁷	6.9	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	99.0	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	92.0	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	90.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	80.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	102	°C	ISO 306/B50

--	105	°C	ISO 306/B120
Injection	Nominal Value	Unit	
Drying Temperature			
--	85.0	°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	190 to 200	°C	
Middle Temperature	210 to 220	°C	
Front Temperature	230 to 240	°C	
Nozzle Temperature	240	°C	
Mold Temperature	40.0 to 80.0	°C	
Injection Pressure	49.0 to 245	MPa	
Back Pressure	0.490 to 1.96	MPa	
Screw Speed	50 to 150	rpm	
NOTE			
1.	50 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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