

Starex SF-0505EH

Methyl Methacrylate / ABS

SAMSUNG SDI CO., LTD.

Message:

Starex SF-0505EH is a Methyl Methacrylate / ABS (MABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Primary characteristic: flame rated.

General Information			
UL YellowCard	E115797-460972		
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)	11	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.40 to 0.48	%	
Across Flow : 3.20 mm	0.41 to 0.51	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2200	MPa	ASTM D638
Tensile Strength			
Yield ²	51.0	MPa	ASTM D638
Yield	53.0	MPa	ISO 527-2/5
Break ³	39.0	MPa	ASTM D638
Tensile Elongation ⁴ (Break)	30	%	ASTM D638
Flexural Modulus			
-- ⁵	2300	MPa	ASTM D790
-- ⁶	2350	MPa	ISO 178
Flexural Strength			
-- ⁷	77.0	MPa	ASTM D790
-- ⁸	79.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	5.8	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	69	J/m	ASTM D256
23°C, 6.35 mm	59	J/m	ASTM D256
23°C ¹⁰	6.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 6.40 mm	86.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	98.0	°C	ISO 75-2/A

Flammability	Nominal Value	Test Method
Flame Rating (1.50 to 3.00 mm)	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature		
--	85.0	°C
Desiccant Dryer	80.0	°C
Drying Time		
--	4.0	hr
Desiccant Dryer	4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	200 to 210	°C
Middle Temperature	210 to 220	°C
Front Temperature	220 to 230	°C
Nozzle Temperature	240	°C
Mold Temperature	60.0	°C
Injection Pressure	49.0 to 206	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	30 to 70	rpm
NOTE		
1.	5.0 mm/min	
2.	5.0 mm/min	
3.	5.0 mm/min	
4.	5.0 mm/min	
5.	2.8 mm/min	
6.	2.0 mm/min	
7.	2.8 mm/min	
8.	2.0 mm/min	
9.	Thickness: 4 mm	
10.	Thickness: 4 mm	

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