

Starex HF-0660IW

Acrylonitrile Butadiene Styrene
SAMSUNG SDI CO., LTD.

Message:
WNP high flow ABS material

General Information			
Features	High Flow		
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)	3.5	g/10 min	ASTM D1238, ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2/50
Tensile Strength			
Yield ¹	39.0	MPa	ASTM D638
Yield	47.0	MPa	ISO 527-2/50
Break	35.0	MPa	ISO 527-2/50
Tensile Strain (Break)	18	%	ISO 527-2/50
Flexural Modulus			
-- ²	2200	MPa	ASTM D790
-- ³	2500	MPa	ISO 178
Flexural Strength			
-- ⁴	59.0	MPa	ASTM D790
-- ⁵	76.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶ (23°C)	20	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 6.35 mm	200	J/m	ASTM D256
23°C ⁷	20	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 4.00 mm	88.0	°C	ISO 75-2/B
0.45 MPa, Annealed	98.0	°C	ISO 75-2/B
1.8 MPa, Unannealed, 4.00 mm	75.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	94.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	95.0	°C	ISO 306/B50
--	98.0	°C	ISO 306/B120

Optical	Nominal Value	Unit	Test Method
Yellowness Index (3.20 mm)	11 to 21	YI	ASTM D1925
Injection	Nominal Value	Unit	
Drying Temperature			
--	80.0	°C	
Desiccant Dryer	80.0	°C	
Drying Time			
--	4.0	hr	
Desiccant Dryer	2.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	200 to 210	°C	
Middle Temperature	210 to 220	°C	
Front Temperature	220 to 230	°C	
Nozzle Temperature	230	°C	
Mold Temperature	60.0 to 80.0	°C	
Injection Pressure	196	MPa	
Back Pressure	7.85 to 11.8	MPa	
Screw Speed	30 to 120	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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