

Starex BF-0670T

Methyl Methacrylate / ABS

SAMSUNG SDI CO., LTD.

Message:

Scratch resistant material that is applied to the exterior material of electric products and household appliances

General Information			
UL YellowCard	E115797-100067827		
Features	High Scratch Resistance		
Uses	Electrical Housing		
	Household Goods		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
220°C/10.0 kg	25	g/10 min	ASTM D1238
220°C/10.0 kg	24	g/10 min	ISO 1133
Molding Shrinkage			
Flow : 3.20 mm	0.30	%	ASTM D955
Across Flow : 3.20 mm	0.30	%	ASTM D955
Across Flow : 3.20 mm	0.40	%	ISO 2577
Flow : 3.20 mm	0.40	%	ISO 2577

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	114		ASTM D785
R-Scale	115		ISO 2039-2
Pencil Hardness ¹	F		JIS K5401

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	2100	MPa	ASTM D638
--	2500	MPa	ISO 527-2/50
Tensile Strength			
Yield ³	49.0	MPa	ASTM D638
Yield	52.0	MPa	ISO 527-2/50
Break ⁴	36.0	MPa	ASTM D638
Break	36.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁵	18	%	ASTM D638
Break	22	%	ISO 527-2/50
Flexural Modulus			

-- 6	2400	MPa	ASTM D790
-- 7	2360	MPa	ISO 178
Flexural Strength			
-- 8	67.0	MPa	ASTM D790
-- 9	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹⁰ (23°C)	8.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	79	J/m	ASTM D256
23°C, 6.35 mm	64	J/m	ASTM D256
23°C ¹¹	7.4	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	90.0	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	83.0	°C	ISO 75-2/B
0.45 MPa, Annealed	92.0	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	80.0	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	72.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	86.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	90.0	°C	ISO 306/B50
--	92.0	°C	ISO 306/B120
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.800 mm	HB		
2.00 mm	HB		
3.00 mm	HB		
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.	Condition: 500g	
2.	5.0 mm/min	
3.	5.0 mm/min	
4.	5.0 mm/min	
5.	5.0 mm/min	
6.	2.8 mm/min	
7.	2.0 mm/min	
8.	2.8 mm/min	
9.	2.0 mm/min	
10.	Thickness: 4 mm	
11.	Thickness: 4 mm	

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

