

Starex TX-0510

Methyl Methacrylate / ABS

SAMSUNG SDI CO., LTD.

Message:

Starex TX-0510 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			
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)	16	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.43 to 0.52	%	
Across Flow : 3.20 mm	0.44 to 0.54	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	109		ASTM D785
R-Scale	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2000	MPa	ASTM D638
Tensile Strength			
Yield ²	44.0	MPa	ASTM D638
Yield	47.0	MPa	ISO 527-2/50
Break ³	32.0	MPa	ASTM D638
Tensile Elongation ⁴ (Break)	19	%	ASTM D638
Flexural Modulus			
-- ⁵	2100	MPa	ASTM D790
-- ⁶	2200	MPa	ISO 178
Flexural Strength			
-- ⁷	64.0	MPa	ASTM D790
-- ⁸	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	13	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	150	J/m	ASTM D256
23°C, 6.35 mm	150	J/m	ASTM D256
23°C ¹⁰	12	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	7.80	°C	ASTM D648

Vicat Softening Temperature	88.0	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	HB		
3.00 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature			
--	80.0	°C	
Desiccant Dryer	80.0	°C	
Drying Time			
--	2.0	hr	
Desiccant Dryer	2.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	200 to 215	°C	
Middle Temperature	215	°C	
Front Temperature	215 to 230	°C	
Nozzle Temperature	230	°C	
Mold Temperature	40.0 to 60.0	°C	
Injection Pressure	49.0 to 196	MPa	
Back Pressure	0.490 to 4.90	MPa	
Screw Speed	10 to 100	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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