

Starex TF-0956

Polymethyl Methacrylate Acrylic
SAMSUNG SDI CO., LTD.

Message:

Starex TF-0956 is a Polymethyl Methacrylate Acrylic product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.
Characteristics include:
Flame Rated
Impact Resistant

General Information			
UL YellowCard	E115797-100039315		
Features	High Impact Resistance		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238, ISO 1133
220°C/10.0 kg	6.0	g/10 min	
230°C/3.8 kg	3.0	g/10 min	
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.30 to 0.37	%	
Across Flow : 3.20 mm	0.35 to 0.42	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785, ISO 2039-2
Pencil Hardness ¹	H		JIS K5401
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	2200	MPa	ASTM D638
--	2500	MPa	ISO 527-2/50
Tensile Strength			
Yield ³	51.0	MPa	ASTM D638
Yield	62.0	MPa	ISO 527-2/50
Break ⁴	45.0	MPa	ASTM D638
Break	50.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁵	50	%	ASTM D638
Break	17	%	ISO 527-2/50
Flexural Modulus			
-- ⁶	2000	MPa	ASTM D790
-- ⁷	2200	MPa	ISO 178
Flexural Strength			
-- ⁸	74.0	MPa	ASTM D790
-- ⁹	80.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹⁰ (23°C)	4.7	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	49	J/m	ASTM D256
23°C, 6.35 mm	44	J/m	ASTM D256
23°C ¹¹	3.9	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	80.0	°C	ASTM D648
Vicat Softening Temperature	93.0	°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			
--	90.0	°C	
Desiccant Dryer	90.0	°C	
Drying Time			
--	2.0 to 4.0	hr	
Desiccant Dryer	2.0 to 3.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	220 to 230	°C	
Middle Temperature	230 to 240	°C	
Front Temperature	240 to 250	°C	
Nozzle Temperature	250	°C	
Mold Temperature	50.0 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.	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		

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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

