

TECHNICAL DATA SHEET

STAREX BF-0677HF

Lotte Chemical Corporation
MABS

Processing

Injection molding

Pellets, Natural color

Applications

Electrical and electrical

Delivery Form

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	19	g/10min	ISO 1133
Temperature	220	°C	
Load	10	kg	
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
Melt flow index, MFI	19	g/10min	ASTM D 1238
Temperature	220	°C	
Load	10	kg	
Mold shrinkage, MD	0.004	mm/mm	ASTM D 955
Mold shrinkage, TD	0.005	mm/mm	ASTM D 955
Mechanical Properties	Value	Unit	Standard
Tensile modulus	2600	MPa	ISO 527
Yield stress	53	MPa	ISO 527
Stress at break	38	MPa	ISO 527
Strain at break	20	%	ISO 527
Poisson's ratio	0.35		ISO 527
Flexural modulus, 23°C	2600	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	10	kJ/m ²	ISO 180/1A
Rockwell hardness	R 116		ISO 2039-2
Tensile modulus	2400	MPa	ASTM D 638
Tensile strength at yield	47	MPa	ASTM D 638

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Mechanical Properties	Value	Unit	Standard
Tensile strength at break	29	MPa	ASTM D 638
Elongation at break	15	%	ASTM D 638
Flexural modulus	2500	MPa	ASTM D 790
Flexural strength	69	MPa	ASTM D 790
Rockwell hardness	R 114		ASTM D 785
Izod impact notched, 1/8 in	120	J/m	ASTM D 256
Izod impact notched, 1/4 in	88	J/m	ASTM D 256
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	76	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	88	°C	ISO 75-1/-2
Vicat softening temperature, B	95	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3	mm	
UL 94 flame rating	HB		UL 94
Thickness tested	1.5	mm	
DTUL @ 66 psi	93	°C	ASTM D 648
DTUL @ 264 psi	84	°C	ASTM D 648
Vicat temperature	96	°C	ASTM D 1525
Other Properties	Value	Unit	Standard
Density	1130	kg/m ³	ISO 1183
Density	1130	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	85	°C	
Pre-drying - time	2 - 4	h	
Melt temperature	240	°C	
Mold temperature	40 - 80	°C	
Feed temperature	0.05	°C	
Zone 1	190 - 200	°C	
Zone 2	210 - 220	°C	
Zone 3	230 - 240	°C	

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Processing Recommendation Injection Molding	Value	Unit	Standard
Nozzle temperature	240	°C	
Screw speed	50 - 150	rpm	
Injection pressure	49 - 250	MPa	
Back pressure	0.5 - 2	MPa	