

Starex SF-0950

Lotte Chemical Corporation - Methyl Methacrylate / ABS

General Information

General			
Uses	• Electrical/Electronic Applications		
Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.10		ASTM D792
Density (Natural)	1.10	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	13	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	13	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	363000	psi	ASTM D638
Tensile Modulus	377000	psi	ISO 527-1/50
Tensile Strength ² (Yield)	7400	psi	ASTM D638
Tensile Stress (Yield)	7980	psi	ISO 527-2/50
Tensile Strength ² (Break)	4930	psi	ASTM D638
Tensile Stress (Break)	5800	psi	ISO 527-2/50
Flexural Modulus ³	377000	psi	ASTM D790
Flexural Modulus ⁴	392000	psi	ISO 178
Flexural Strength ³	10700	psi	ASTM D790
Flexural Stress ⁴	12300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	3.8	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	2.1	ft·lb/in	
73°F, 0.250 in	1.8	ft·lb/in	
Notched Izod Impact Strength ⁵ (73°F)	4.3	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785
Rockwell Hardness (R-Scale)	116		ISO 2039-2
Pencil Hardness ⁶	H		JIS K5401
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	208	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	196	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	198	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	172	°F	

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Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	212	°F	ISO 306/B50

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		HB	
0.12 in		HB	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176	°F
Hot Air Dryer	185	°F
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	392 to 410	°F
Middle Temperature	410 to 428	°F
Front Temperature	446	°F
Nozzle Temperature	464	°F
Mold Temperature	140	°F
Injection Pressure	10700 to 34100	psi
Back Pressure	71.1 to 284	psi
Screw Speed	30 to 70	rpm

Injection Notes

Hot Runner Temperature: 240°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 0.20 in/min

³ 0.11 in/min

⁴ 0.079 in/min

⁵ 4mm

⁶ 500g