Starex TX-0510T

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/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	16	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	16	g/10 min	ISO 1133
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	319000	psi	ISO 527-1/50
Tensile Strength [2] (Yield)	6400	psi	ASTM D638
Tensile Stress (Yield)	6820	psi	ISO 527-2/50
Tensile Stress (Break)	5080	psi	ISO 527-2/50
Tensile Strain (Break)	16	%	ISO 527-2/50
Flexural Modulus [3]	305000	psi	ASTM D790
Flexural Modulus [4]	319000	psi	ISO 178
Flexural Strength [3]	9250	psi	ASTM D790
Flexural Stress [4]	10200	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	6.2	ft·lb/in²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	2.8	ft·lb/in	ASTM D256
Notched Izod Impact Strength [5] (73°F)	5.7	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	109		ASTM D785
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	181	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Annealed, 0.157 in	187	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	158	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Annealed, 0.157 in	176	°F	
Vicat Softening Temperature	190	°F	ISO 306/B50
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.06 in	HB		
0.12 in	HB		
Optical	**Nominal Value**	**Unit**	**Test Method**
Light Transmittance (3200.0 mil)	88.0	%	ASTM D1003

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Optical	Nominal Value	Unit	Test Method
Haze (126.0 mil)	2.80	%	ASTM D1003

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176	°F
Hot Air Dryer	176	°F
Drying Time		
Desiccant Dryer	2.0 to 4.0	hr
Hot Air Dryer	4.0 to 6.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	356 to 374	°F
Middle Temperature	392 to 410	°F
Front Temperature	428 to 446	°F
Nozzle Temperature	446	°F
Mold Temperature	122 to 158	°F
Injection Pressure	7110 to 28400	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 220°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