

Starex BF-0670T

Lotte Chemical Corporation - Methyl Methacrylate / ABS

Wednesday, March 9, 2022

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.12	g/cm ³	ASTM D792
Density (Natural)	1.12	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	25	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	24	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.30	%	ASTM D955
Molding Shrinkage - Across Flow (3.20 mm)	0.30	%	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	0.40	%	
Flow : 2.00 mm	0.40	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	2080	MPa	ASTM D638
Tensile Modulus	2500	MPa	ISO 527-1/50
Tensile Strength ² (Yield)	49.0	MPa	ASTM D638
Tensile Stress (Yield)	52.0	MPa	ISO 527-2/50
Tensile Strength ² (Break)	36.3	MPa	ASTM D638
Tensile Stress (Break)	36.0	MPa	ISO 527-2/50
Tensile Elongation ² (Break)	18	%	ASTM D638
Tensile Strain (Break)	22	%	ISO 527-2/50
Flexural Modulus ³	2350	MPa	ASTM D790
Flexural Modulus ⁴	2360	MPa	ISO 178
Flexural Strength ³	66.7	MPa	ASTM D790
Flexural Stress ⁴	70.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (23°C)	8.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
23°C, 3.18 mm	78	J/m	
23°C, 6.35 mm	64	J/m	
Notched Izod Impact Strength ⁵ (23°C)	7.4	kJ/m ²	ISO 180/1A

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ASTM D785
Rockwell Hardness (R-Scale)	115		ISO 2039-2
Pencil Hardness			JIS K5401
-- ⁶		F	
-- ⁷		F	

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed, 6.40 mm	90.0	°C	ASTM D648
Deflection Temperature Under Load 0.45 MPa, Unannealed, 4.00 mm	83.0	°C	ISO 75-2/B
Deflection Temperature Under Load 0.45 MPa, Annealed, 4.00 mm	92.0	°C	ISO 75-2/B
Deflection Temperature Under Load 1.8 MPa, Unannealed, 6.40 mm	80.0	°C	ASTM D648
Deflection Temperature Under Load 1.8 MPa, Unannealed, 4.00 mm	72.0	°C	ISO 75-2/A
Deflection Temperature Under Load 1.8 MPa, Annealed, 4.00 mm	86.0	°C	ISO 75-2/A
Vicat Softening Temperature --	92.0	°C	ISO 306/B120
--	92.0	°C	ISO 306/B50
--	90.0	°C	ISO 306/B50

Flammability	Nominal Value	Unit	Test Method
Flame Rating 0.8 mm	HB		UL 94
2.0 mm	HB		
3.0 mm	HB		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	80	°C
Hot Air Dryer	85	°C
Drying Time		
Desiccant Dryer	2.0 to 3.0	hr
Hot Air Dryer	2.0 to 4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	190 to 200	°C
Middle Temperature	210 to 220	°C
Front Temperature	230 to 240	°C
Nozzle Temperature	240	°C
Mold Temperature	40 to 80	°C
Injection Pressure	49.0 to 245	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 240°C

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Notes

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

² 5.0 mm/min

³ 2.8 mm/min

⁴ 2.0 mm/min

⁵ 4mm

⁶ 500g

⁷ 1000g

