

Starex BF-0930

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)	1.13	g/cm ³	ASTM D792
Density (Natural)	1.13	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	33	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	33	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.35 to 0.43	%	ASTM D955
Molding Shrinkage - Across Flow (3.20 mm)	0.36 to 0.45	%	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	0.36 to 0.45	%	
Flow : 2.00 mm	0.35 to 0.43	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	2600	MPa	ASTM D638
Tensile Modulus	2900	MPa	ISO 527-1/50
Tensile Strength ² (Yield)	57.0	MPa	ASTM D638
Tensile Stress (Yield)	73.0	MPa	ISO 527-2/50
Tensile Strength ² (Break)	41.0	MPa	ASTM D638
Tensile Stress (Break)	72.0	MPa	ISO 527-2/50
Tensile Elongation ² (Break)	19	%	ASTM D638
Tensile Strain (Break)	5.0	%	ISO 527-2/50
Flexural Modulus ³	2600	MPa	ASTM D790
Flexural Modulus ⁴	3000	MPa	ISO 178
Flexural Strength ³	87.0	MPa	ASTM D790
Flexural Stress ⁴	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (23°C)	2.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ⁵ (23°C)	25	kJ/m ²	ISO 179/1eU
Notched Izod Impact			ASTM D256
23°C, 3.18 mm	20	J/m	
23°C, 6.35 mm	20	J/m	
Notched Izod Impact Strength ⁵ (23°C)	2.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			ASTM D4812
-5°C, 3.18 mm	250	J/m	
-5°C, 6.35 mm	230	J/m	
Unnotched Izod Impact Strength ⁵ (23°C)	25	kJ/m ²	ISO 180/1U
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785

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Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ISO 2039-2
Pencil Hardness ⁶	2H		JIS K5401

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed, 6.40 mm	89.0	°C	ASTM D648
Deflection Temperature Under Load 0.45 MPa, Unannealed, 4.00 mm	87.0	°C	ISO 75-2/B
Deflection Temperature Under Load 1.8 MPa, Unannealed, 6.40 mm	79.0	°C	ASTM D648
Deflection Temperature Under Load 1.8 MPa, Unannealed, 4.00 mm	76.0	°C	ISO 75-2/A
Vicat Softening Temperature	94.0	°C	ISO 306/B50

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	80	°C
Hot Air Dryer	80	°C
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	200 to 210	°C
Middle Temperature	210 to 220	°C
Front Temperature	220 to 230	°C
Nozzle Temperature	230	°C
Mold Temperature	60	°C
Injection Pressure	235	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	30 to 70	rpm

Injection Notes

Hot Runner Temperature: 230°C

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