

STAREX BF-0930

MABS

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	33	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	33	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0039	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.004	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Modulus	2900	MPa	ISO 527
Yield stress	73	MPa	ISO 527
Stress at break	72	MPa	ISO 527
Strain at break	5	%	ISO 527
Flexural modulus, 23°C	3000	MPa	ISO 178
Flexural strength	100	MPa	ISO 178
Charpy impact strength, +23°C	25	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	2	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	25	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	2	kJ/m ²	ISO 180/1A
Rockwell hardness	R 121	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2600	MPa	ASTM D 638
Tensile Strength at Yield	57	MPa	ASTM D 638
Tensile Strength at Break	41	MPa	ASTM D 638
Elongation at Break	19	%	ASTM D 638
Flexural Modulus	2600	MPa	ASTM D 790
Flexural Strength	87	MPa	ASTM D 790
Rockwell Hardness	R 118	-	ASTM D 785
Izod Impact notched, 1/8 in	20	J/m	ASTM D 256
Izod Impact notched, 1/4 in	20	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	250	J/m	ASTM D 256
Izod Impact unnotched, 1/4 in	230	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	76	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	87	°C	ISO 75-1/-2
Vicat softening temperature, B	94	°C	ISO 306
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 66 psi	89	°C	ASTM D 648
DTUL @ 264 psi	79	°C	ASTM D 648
Other properties			
Density	1130	kg/m ³	ISO 1183
Density	1130	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-

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Processing humidity	≤0.05	%	-
Melt temperature	230	°C	-
Mold temperature	60	°C	-
Zone 1	200 - 210	°C	-
Zone 2	210 - 220	°C	-
Zone 3	220 - 230	°C	-
Nozzle temperature	230	°C	-
Screw speed	30 - 70	rpm	-
Injection pressure	240	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Delivery form

Pellets, Natural Color

Applications

Electrical and Electronical

Regional Availability

North America, Europe, Asia Pacific