

**STAREX BF-0677HF**

MABS

Lotte Chemical Corporation

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	19	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	19	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.004	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.005	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	2600	MPa	ISO 527
Yield stress	53	MPa	ISO 527
Stress at break	38	MPa	ISO 527
Strain at break	20	%	ISO 527
Flexural modulus, 23°C	2600	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Charpy notched impact strength, +23°C	10	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	10	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 116	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Modulus	2400	MPa	ASTM D 638
Tensile Strength at Yield	47	MPa	ASTM D 638
Tensile Strength at Break	29	MPa	ASTM D 638
Elongation at Break	15	%	ASTM D 638
Flexural Modulus	2500	MPa	ASTM D 790
Flexural Strength	69	MPa	ASTM D 790
Rockwell Hardness	R 114	-	ASTM D 785
Izod Impact notched, 1/8 in	120	J/m	ASTM D 256
Izod Impact notched, 1/4 in	88	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	76	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	88	°C	ISO 75-1/-2
Vicat softening temperature, B	95	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 66 psi	93	°C	ASTM D 648
DTUL @ 264 psi	84	°C	ASTM D 648
Vicat Temperature	96	°C	ASTM D 1525
<b>Other properties</b>			
Density	1130	kg/m <sup>3</sup>	ISO 1183
Density	1130	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	240	°C	-
Mold temperature	40 - 80	°C	-
Feed temperature	0.05	°C	-
Zone 1	190 - 200	°C	-
Zone 2	210 - 220	°C	-
Zone 3	230 - 240	°C	-
Nozzle temperature	240	°C	-
Screw speed	50 - 150	rpm	-
Injection pressure	49 - 250	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