

## ISO Property

starex®	Grade	HF-0670
	Resin Type	ABS

Item	Measuring Method	Condition	Unit	Value
Physical				
Specific Gravity	ISO 1183	Natural or representative color	-	1.04
Melt Flow Index	ISO 1133	200°C, 5kg	g/10min	4.5
Mold Shrinkage(MD)	ISO 294-4	Flow at 2mm(MD)	%	0.3 ~ 0.6
Mold Shrinkage(TD)	ISO 294-4	X-Flow at 2mm(TD)	%	0.3 ~ 0.6
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	42
Tensile Strain at break	ISO 527	50mm/min	%	-
Tensile Modulus	ISO 527	50mm/min	MPa	2300
Tensile Strength at break	ISO 527	50mm/min	MPa	33
Flexural Strength	ISO 178	2mm/min	MPa	68
Flexural Modulus	ISO 178	2mm/min	MPa	2400
Izod Impact Strength(notched)	ISO 180 1A	at 23°C, 4mm	kJ/m <sup>2</sup>	18
Charpy Impact Strength(V-notched)	ISO 179 1eA	at 23°C, 4mm	kJ/m <sup>2</sup>	20
Rockwell Hardness	ISO 2039-2	R-Scale	-	109
Thermal				
Heat Deflection Temperature(Unannealed)	ISO 75-2	1.8MPa, 4.0mm	°C	74
Heat Deflection Temperature(Unannealed)	ISO 75-2	0.45MPa, 4.0mm	°C	-
VICAT Softening Temperature	ISO 306	B/50	°C	92
Flammability				
Flammability	UL94	HB	mm	1.5/3.0

1. The above figures are the representative values based on NP, which may vary from color to color, and can be used as a reference only for the purpose of selecting materials.

2. The above figures are basic guidelines for selecting materials; therefore, they are not regarded as the official specifications for materials involved, and cannot be used for the purpose of designing a mold.
3. The above values can be adjusted in accordance with processing conditions, and the specific change in value is allowed only within a limited range in which adjustment has no adverse or negative impact on the final product.

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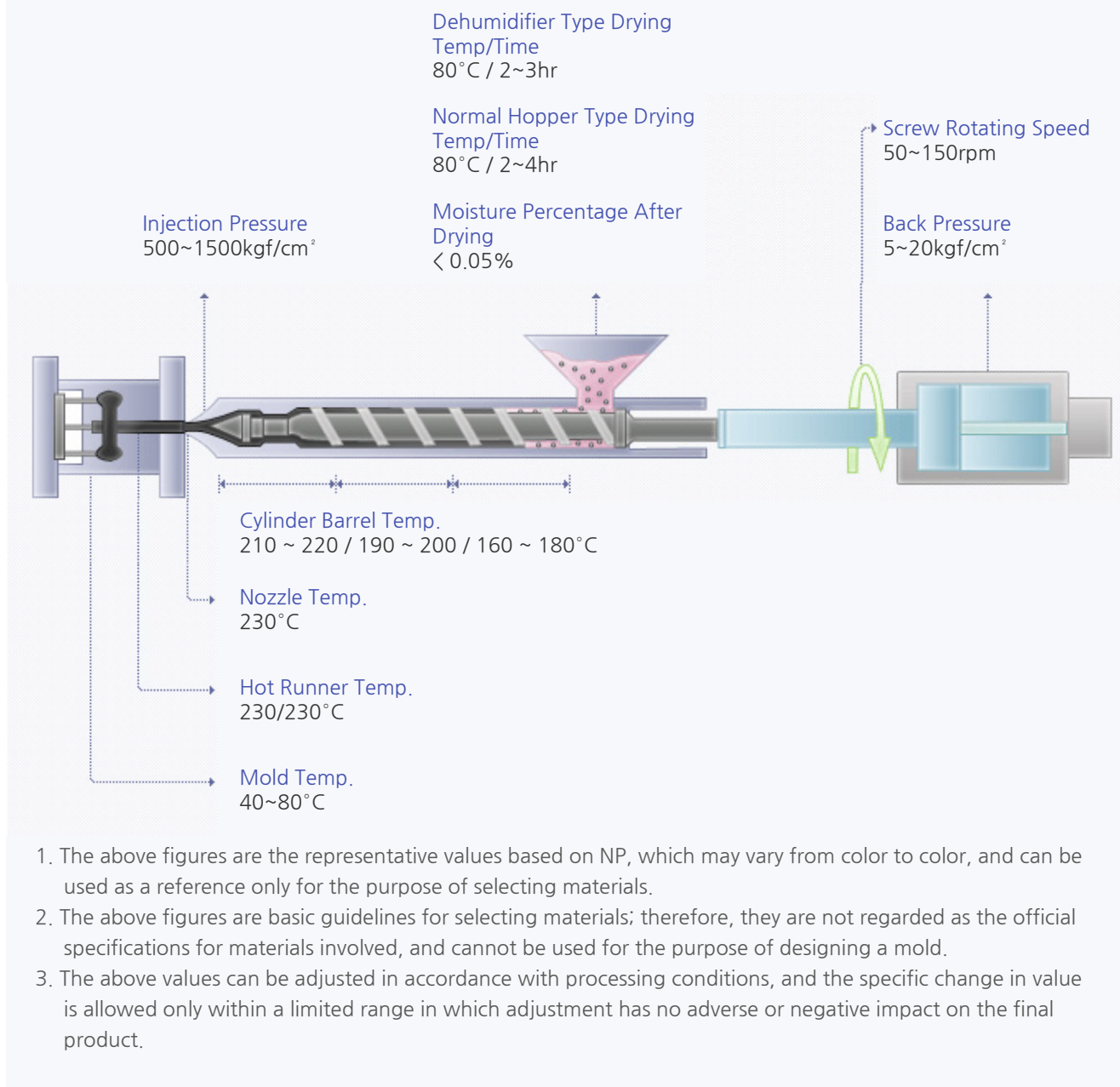
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※ The last update date : 08/31/2018

## Processing Guide

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	Resin Type	ABS

Item		Unit	Representative	
Mold Temp.(Standard Molding)		Stationary Platen	°C	40 ~ 80
		Moving Platen		
Hot Runner Temp.		Manifolder	°C	230
		Valve Nozzle		230
Nozzle Temp.			°C	230
Cylinder Barrel Temp.		Front Part	°C	210 ~ 220
		Mid Part	°C	190 ~ 200
		Rear Part	°C	160 ~ 180
Injection Pressure			kgf/cm <sup>2</sup>	500~1500
Drying Condition	Dehumidifier Type	Drying Temp	°C	80
		Drying Time	hr	2~3
	Normal Hopper Type	Drying Temp	°C	80
		Drying Time	hr	2~4
Moisture Percentage After Drying			%	<0.05
Screw Rotating Speed			rpm	50 ~ 150
Back Pressure			kgf/cm <sup>2</sup>	5 ~ 20



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