



CHEIL INDUSTRIES

R&D Center, Chemicias Division, Cheil Industries Inc.  
332-2, Gochun-dong, Euiwang-Shi, Kyunggi-do,  
Korea

## Properties of STAREX ABS HF-0660I

(incl. glow wire flammability)

ISO TDS 09-04-21

Properties at 23 °C	Test Method	Test Condition	Unit	Cheil Industries.
				HF-0660I
<b>Rheological Properties</b>				
Melt Flow Index	ISO 1133	200°C/5Kg	g/10min	3
Molding Shrinkage (Longitudinal Shrinkage)	-	3 mm Thickness	%	0.5~0.6
Molding Shrinkage (Transversal Shrinkage)	-	3 mm Thickness	%	0.4~0.5
<b>Mechanical Properties</b>				
Tensile Strength at Yield	ISO 527-1	50 mm/min	Mpa	41
Elongation at Yield	ISO 527-1	50 mm/min	%	20
Elongation at Break	ISO 527-1	50 mm/min	%	50
Flexural Strength	ISO 178	2 mm/min	Mpa	58
Flexural Modulus	ISO 178	2 mm/min	Mpa	1,750
Charpy Impact (notched)	ISO 179	4 mm, 23 °C	KJ/m2	22
Charpy Impact (notched)	ISO 179	4 mm, -30 °C	KJ/m2	10
Rockwell Hardness	ISO 2039-2	R-scale	-	107
<b>Thermal Properties</b>				
Vicat Softening Temperature	ISO 306 B50	50 N	°C	96
Heat Deflection Temperature	ISO 75-2 Af	1.8 Mpa	°C	71
Coefficient of Linear Expansion	ISO 11359	23~85 °C	10 <sup>-6</sup> mm/mm · °C	85
Thermal Conductivity	-	-	W/m · K	0.15
Glow-Wire Flammability	IEC 60695-2-12	-	°C	650
Glow-Wire Ignition	IEC 60695-2-13	-	°C	675
<b>Electrical Properties</b>				
Relative Permittivity	IEC 60250	100Hz	-	3.9
Relative Permittivity	IEC 60250	1Hz	-	3.5
Volume Resistivity	IEC 6093	-	ohm	10 <sup>12</sup>
Surface Resistivity	IEC 6093	-	ohm	10 <sup>13</sup>
<b>Other Properties</b>				
Specific Gravity	ISO 1183	-	g/cm3	1.04
Water Absorptoin	ISO 62	23°C, 50% HR	%	1.6
UL 94 Rating	UL 94	1.0 mm Thickness	Class	HB
<b>Processing Condition</b>				
Pre-Drying	-	80 °C	hr	2~4
Injection Molding Temperature	-	-	°C	190~230
Mold Temperature	-	-	°C	60