

# VALUPAK™ Resins



Grade: ABSLG5035

Molding Grade ABS Low Gloss

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## Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.05	D792
Melt Flow (230°C/3.8 kg)	5.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	290,000 psi	D638
Tensile Strength @ Yield	5,800 psi	D638
Flexural Modulus	300,000 psi	D790
Flexural Strength @ Yield	8,500 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125)	3.5 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125)	170°F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.005 - .008 in/in	D955
<b>Gloss (60°F)</b>	<60%	D523

The information provided above is based upon typical values, and are intended only as guides. Star Plastics, Inc./SDR Inc. assumes no obligation or liability for any advice furnished or for any results obtained with respect to this information. **No guarantees or warranties are expressed or implied.**

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## Recommended Processing Guidelines

	Nominal Values (metric)
Drying Time and Temperature	2.0 - 4.0 hr, 180°F - 200°F
Suggested Max Moisture	0.15%
Rear Temperature	370°F - 425°F
Middle Temperature	400°F - 450°F
Front Temperature	425°F - 475°F
Nozzle Temperature	425°F - 525°F
Processing (Melt) Temperature	425°F - 525°F
Mold Temperature	120°F - 170°F
Back Pressure	25 - 100 psi
Screw Speed	25 - 75 RPM

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.

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