

STAR PRIME™ Resins



Grade: ABS450FR

Molding Grade ABSFR RoHS Compliant FR ABS

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Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.22	D792
Melt Flow (230 °C/3.8 kg)	8.0 g/10 min	D1238
Mechanical		
Tensile Modulus	320,000 psi	D638
Tensile Strength at Yield	5,500 psi	D638
Flexural Modulus	330,000 psi	D790
Flexural Strength at Yield	9,500 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125 in)	3.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	170 °F	D648
Mold Shrinkage		
Linear Flow	.005 - .008 in/in	D955
UL Rating	V0 (1.5 mm); V-0, 5VA (3.0 mm)	UL 94

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
Drying Time and Temperature	2.0 - 4.0 hrs at 170 - 190 °F
Suggested Max Moisture	0.15%
Rear Temperature	330 - 360 °F
Middle Temperature	350 - 400 °F
Front Temperature	375 - 450 °F
Nozzle Temperature	375 - 450 °F
Processing (melt) Temperature	375 - 450 °F
Mold Temperature	120 - 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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