

# STAR PRIME™ Resins



**Grade: ABS6044, ABS6044UV**

Molding Grade ABS and w/ UV; can be Injection Molded or Extruded

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## Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.04	D792
Melt Flow (230 °C/3.8 kg)	5.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	355,000 psi	D638
Tensile Strength at Yield	6,700 psi	D638
Flexural Modulus	353,000 psi	D790
Flexural Strength at Yield	10,800 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	5.0 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	182 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.004 - .008 in/in	D955
<b>UL Rating</b>	<b>HB (1.5 mm)</b>	<b>UL 94</b>

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 180 - 200 °F
Suggested Max Moisture	0.15%
Rear Temperature	370 - 425 °F
Middle Temperature	400 - 450 °F
Front Temperature	425 - 475 °F
Nozzle Temperature	425 - 525 °F
Processing (melt) Temperature	425 - 525 °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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