

VALUPAK™ Resins



Grade: ABS9020
Molding Grade ABS

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Typical Material Properties

| Physical | Nominal Values | ASTM Test |
|---------------------------------------|-------------------|-----------|
| Specific Gravity | 1.05 | D792 |
| Melt Flow (230 °C/3.8 kg) | 9.0 g/10 min | D1238 |
| Mechanical | | |
| Tensile Modulus | 330,000 psi | D638 |
| Tensile Strength at Yield | 6,000 psi | D638 |
| Flexural Modulus | 350,000 psi | D790 |
| Flexural Strength at Yield | 10,000 psi | D790 |
| Impact | | |
| Notched Izod Impact (73 °F, 0.125 in) | 2.0 ft-lb/in | D256 |
| Thermal | | |
| DTUL @ 264 psi-unannealed (0.125 in) | 180 °F | D648 |
| Mold Shrinkage | | |
| Linear Flow | .004 - .008 in/in | D955 |

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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