

**Grade: ABSHF**  
Molding Grade High Flow 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)	6.0 g/10 min	D1238
<b>Mechanical</b>		
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
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	2.5 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	180 °F	D648
<b>Mold Shrinkage</b>		
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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