

GRADE: ABS 35

Molding Grade ABS

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.05	D792
Melt Flow (230°C/3.8 kg)	4.0 g/10 min	D1238
Mechanical		
Tensile Modulus	300,000 psi	D638
Tensile Strength @ Yield	5,500 psi	D638
Flexural Modulus	300,000 psi	D790
Flexural Strength @ Yield	9,500 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	3.0 ft-lb/in	D256
Thermal		
HDT @ 264 PSI – unannealed (0.125)	180°F	D648
Mold Shrinkage		
Linear Flow	.004 – .008 in/in	D955

The information provided above is based upon typical values, and is intended only as a guide. Star Plastics, LLC 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.*

Orion® is a registered trademark of Star Plastics, LLC, its subsidiaries or affiliates.

Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	3.0 – 4.0 hrs, 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.