

## GRADE: ABS3535

Molding Grade ABS

### Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.05	D792
Melt Flow (230°C/3.8 kg)	3.5 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	330,000 psi	D638
Tensile Strength @ Yield	6,000 psi	D638
Flexural Modulus	350,000 psi	D790
Flexural Strength @ Yield	10,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	3.5 ft-lb/in	D256
<b>Thermal</b>		
HDT @ 264 psi-unannealed (0.125)	180°F	D648
<b>Mold Shrinkage</b>		
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<sup>®</sup> is a registered trademark of Star Plastics, LLC, its subsidiaries or affiliates.

### Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	2.0 – 4.0 hrs, 180 – 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.