

# STAR PRIME™ RESINS

Grade: ABSQP6053

Painting Grade ABS (GYS30171)



## 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                      | 350,000 psi       | D638      |
| Tensile Strength @ Yield             | 6,500 psi         | D638      |
| Flexural Modulus                     | 350,000 psi       | D790      |
| Flexural Strength @ Yield            | 10,500 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) | 183 °F            | D648      |
| <b>Mold Shrinkage</b>                |                   |           |
| Linear Flow                          | .004 - .008 in/in | D955      |
| <b>UL Rating</b>                     |                   |           |
|                                      | HB                | UL 94     |

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.

Rev0

Technical Data Sheet  
StarPlastics.com

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# Navigating Custom Compounds