

VALUPAK™ RESINS

Grade: ABSLG5035

Molding Grade ABS, Low Gloss



TYPICAL MATERIAL PROPERTIES

| Physical | Nominal Values | ASTM Test |
|---------------------------------------|-------------------|-----------|
| Specific Gravity | 1.05 | D792 |
| Melt Flow (230°C/3.8 kg) | 5.0 g/10 min | D1238 |
| Mechanical | | |
| Tensile Modulus | 290,000 psi | D638 |
| Tensile Strength @ Yield | 5,800 psi | D638 |
| Flexural Modulus | 300,000 psi | D790 |
| Flexural Strength @ Yield | 8,500 psi | D790 |
| Impact | | |
| Notched Izod Impact (73 °F, 0.125 in) | 3.5 ft-lb/in | D256 |
| Thermal | | |
| DTUL @ 264 psi-unannealed (0.125 in) | 170 °F | D648 |
| Mold Shrinkage | | |
| Linear Flow | .005 - .008 in/in | D955 |
| Gloss (60°) | <60% | D523 |

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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Technical Data Sheet
StarPlastics.com

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Navigating Custom Compounds