

Orion™ 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)	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°F)	<60%	D523

The information provided above is based upon typical values, and are intended only as guides. Star Plastics/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, 180°F - 230°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.

Rev0

Technical Data Sheet
StarPlastics.com

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Navigating Custom Compounds