

Grade: ABS415

Molding Grade ABS w/75% pre-consumer recycled content

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.04	D792
Melt Flow (300°C/1.2 kg)	4.0 g/10 min	D1238
Mechanical		
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
Impact		
Notched Izod Impact (73 °F, 0.125 in)	4.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi-unannealed (0.125 in)	183 °F	D648
Mold Shrinkage		
Linear Flow	.004 - .008 in/in	D955
UL Rating		
	HB(1.5mm)	UL94

The information provided above is based upon typical values and are intended only as guides. 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.*

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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.