

STAR ABS EX4

General	
Availability	Global
Processing Method	Extrusion Molding
Description	Sheet extrusion grade ABS

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.03 g/cm ³	ASTM D792
Melt Mass-Flow Rate	4 g/10 min	ASTM D1238

Mechanical	Nominal Value	Test Method
Tensile Modulus	2030 MPa	ASTM D638
Tensile Stress		ASTM D638
Yield	39 MPa	
Break	28 MPa	
Tensile Elongation		ASTM D638
Yield	3.1%	
Break	31.6%	
Flexural Modulus	2100 MPa	ASTM D790
Flexural Strength	63 MPa	ASTM D790

Impact	Nominal Value	Test Method
Notched Izod Impact	411 J/m	ASTM D256
Dart Impact	33 J	ASTM D3763

Thermal	Nominal Value	Test Method
Deflection Temperature Under Load		D648
.45 MPa, Unannealed, 3.2 mm	93 C	ASTM D256
1.8 MPa, Unannealed, 3.2 mm	80 C	ASTM D3763
Vicat Softening Temperature	106 C	ASTM D1525
CLTE		
Flow: -40 to 40 C	1.01E-4 cm/cm/C	
Transverse: -40 to 40 C	1.04E-4 cm/cm/C	
RTi	60 C	UL 746

Flammability		
Flame Rating (1.5mm)	HB	UL 94

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee as conditions and methods of use are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.

Sheet Extrusion	Nominal Value
Drying Temperature	80 to 95 C
Drying Time	4 hours
Suggested Max Moisture	0.02%
Barrel- Zone 1 Temp	170 - 200 C
Barrel- Zone 2 Temp	180 - 220 C
Barrel- Zone 3 Temp	190 - 225 C
Barrel- Zone 4 Temp	200 - 250 C
Adapter Temp	205 - 250 C
Die Temp	205 - 250 C
Roll Stack Temp- Top	90 -95 C
Roll Stack Temp- Middle	95 - 105 C
Roll Stack Temp- Bottom	100 - 105 C

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