

STAR ABS GP18

General	
Availability	Global
Processing Method	Injection Molding
Features	General purpose injection molding ABS

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.04 g/cm ³	ASTM D792
Melt Mass-Flow Rate	5.6 g/10 min	ASTM D1238
Melt Volume-Flow Rate	18 cm ³ /10min	ISO 1133

Mechanical	Nominal Value	Test Method
Tensile Modulus	2130 MPa	ASTM D638
Tensile Strength		ASTM D638
	Yield	40 MPa
	Break	31 MPa
Tensile Elongation		ASTM D638
	Yield	2%
	Break	20%
	Flexural Modulus	2200 MPa
	Flexural Strength	68 MPa

Impact	Nominal Value	Test Method
Notched Izod Impact	290 J/m	ASTM D256
Dart Impact	30 J	ASTM D3763

Thermal	Nominal Value	Test Method
Deflection Temperature Under Load		D648
	.45 MPa, Unannealed, 3.2 mm	96 C
	1.8 MPa, Unannealed, 3.2 mm	82 C
Vicat Softening Temperature	98 C	ASTM D1525
CLTE		
	Flow: -40 to 40 C	8.85E-5 cm/cm/C
	Transverse: -40 to 40 C	8.85E-5 cm/cm/C
RTi	60 C	UL 746

Flammability	
Flame Rating (1.5mm)	HB
	UL 94

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Injection Processing	Nominal Value
Drying Temperature	80 to 95 C
Drying Time	2 to 4 hours
Suggested Max Moisture	0.10%
Suggested Shot Size	50 to 70%
Rear Temperature	190 to 210 C
Middle Temperature	205 to 225 C
Front Temperature	215 to 240 C
Nozzle Temperature	220 to 260 C
Processing (melt) Temperature	220 to 260 C
Mold Temperature	50 to 70 C
Back Pressure	.3 to .7 MPa
Screw Speed	30 to 60 rpm
Vent Depth	.038 to .051 mm

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