

## STAR ABS HF35

<b>General</b>			
Availability	Global		
Processing Method	Injection Molding		
Description	High flow general purpose ABS		

  

<b>Physical</b>	<b>Nominal Value</b>	<b>Test Method</b>	
Density/Specific Gravity	1.04 g/cm3	ASTM D792	
Melt Mass-Flow Rate	35 g/10 min	ASTM D1238	

  

<b>Mechanical</b>	<b>Nominal Value</b>	<b>Test Method</b>	
Tensile Modulus	2480 MPa	ASTM D638	
Tensile Strength		ASTM D638	
	Yield	46 MPa	
	Break	35 MPa	
Tensile Elongation			ASTM D638
	Yield	2%	
	Break	18%	
	Flexural Modulus	2620 MPa	ASTM D790
	Flexural Strength	79 MPa	ASTM D790

  

<b>Impact</b>	<b>Nominal Value</b>	<b>Test Method</b>	
Notched Izod Impact	240 J/m	ASTM D256	
Dart Impact	21 J	ASTM D3763	

  

<b>Thermal</b>	<b>Nominal Value</b>	<b>Test Method</b>	
Deflection Temperature Under Load		D648	
	.45 MPa, Unannealed, 3.2 mm	95 C	ASTM D256
	1.8 MPa, Unannealed, 3.2 mm	82C	ASTM D3763
Vicat Softening Temperature		99C	ASTM D1525
CLTE			
	Flow: -40 to 40 C	8.8E-5 cm/cm/C	
	Transverse: -40 to 40 C	8.55E-5 cm/cm/C	
RTI		60 C	UL 746

  

<b>Flammability</b>			
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.

<b>Injection Processing</b>	<b>Nominal Value</b>
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 200 C
Middle Temperature	200 to 210 C
Front Temperature	205 to 225 C
Nozzle Temperature	205 to 245 C
Processing (melt) Temperature	205 to 245 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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