

STAR ABS HI15

General	
Availability	Global
Processing Method	Injection Molding
Description	High Impact ABS

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.04 g/cm ³	ASTM D792
Melt Mass-Flow Rate	3.7 g/10 min	ASTM D1238
Melt Volume-Flow Rate	15 cm ³ /10min	ISO 1133

Mechanical	Nominal Value	Test Method
Tensile Modulus	2100 MPa	ASTM D638
Tensile Stress		ASTM D638
	Yield	41 MPa
	Break	31 MPa
Tensile Elongation		ASTM D638
	Yield	2%
	Break	26%
	Flexural Modulus	2200 MPa
	Flexural Strength	68 MPa

Impact	Nominal Value	Test Method
Notched Izod Impact	347 J/m	ASTM D256
		ASTM
Dart Impact	31 J	D3763

Thermal	Nominal Value	Test Method
Deflection Temperature Under Load		D648
	.45 MPa, Unannealed, 3.2 mm	97 C
		ASTM D256
	1.8 MPa, Unannealed, 3.2 mm	82 C
		ASTM D3763
Vicat Softening Temperature	98 C	ASTM D1525
CLTE	Flow: -40 to 40 C	8.82E-5 cm/cm/C

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.

RTi	Transverse: -40 to 40 C	8.64E-5 cm/cm/C	60 C	UL 746
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Flammability				
Flame Rating (1.5mm)			HB	UL 94

	Nominal Value
Injection Processing	
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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