



**Grade: ABS33**  
Molding Grade ABS

**Typical Material Properties**

Physical	Nominal Values	ASTM Test
Specific Gravity	1.05	D792
Melt Flow (230°C/3.8 kg)	4.5 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	300,000 psi	D638
Tensile Strength @ Yield	5,500 psi	D638
Flexural Modulus	300,000 psi	D790
Flexural Strength @ Yield	9,500 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	3.0 ft-lb/in	D256
<b>Thermal</b>		
HDT @ 264 PSI – unannealed (0.125)	180°F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.004 – .008 in/in	D955

**Recommended Processing Guidelines**

	Nominal Values
Drying Time and Temperature	3.0 – 4.0 hrs, 180°F – 200°F
Suggested Max Moisture	0.15%
Rear Temperature	370°F – 425°F
Middle Temperature	400°F – 450°F
Front Temperature	425°F – 475°F
Nozzle Temperature	425°F – 525°F
Processing (Melt) Temperature	425°F – 525°F
Mold Temperature	120°F – 170°F
Back Pressure	25 – 100 psi
Screw Speed	25 – 75 RPM