



**Grade: ABS5035**  
Molding Grade ABS

**Typical Material Properties**

Physical	Nominal Values	ASTM Test
Specific Gravity	1.05	D792
Melt Flow (230°C/3.8 kg)	5.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	290,000 psi	D638
Tensile Strength @ Yield	5,800 psi	D638
Flexural Modulus	300,000 psi	D790
Flexural Strength @ Yield	8,500 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	3.5 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	170 °F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.005 - .008 in/in	D955
<b>UL Rating</b>		
	HB (1.5mm to 2.9mm)	UL94

**Recommended Processing Guidelines**

	Nominal Values
Drying Time and Temperature	2.0 - 4.0 hrs, 180 - 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