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ORION MADE FOR YOU BY STAR PLASTICS

Grade: ABSHFL

Molding Grade High Flow ABS

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.05	D792
Melt Flow (230°C/3.8 kg)	8.0 g/10 min	D1238
Mechanical		
Tensile Modulus	330,000 psi	D638
Tensile Strength @ Yield	6,000 psi	D638
Flexural Modulus	350,000 psi	D790
Flexural Strength @ Yield	10,000 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	2.0 ft-lb/in	D256
Thermal		
DTUL @ 264 PSI – unannealed (0.125)	180 °F	D648
Mold Shrinkage		
Linear Flow	.004 - .008 in/in	D955

Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	2.0 - 4.0 hrs at 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