



GRADE: RE-ABSRC-FR002

Molding Grade ABSFR, w/UV

Including 35% Validated Pre-consumer Recycled Content Materials

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.22	D792
Melt Flow (230°C/3.8 kg)	7.0 g/10 min	D1238
Mechanical		
Tensile Modulus	315,000 psi	D638
Tensile Strength @ Yield	5,300 psi	D638
Flexural Modulus	325,000 psi	D790
Flexural Strength @ Yield	9,300 psi	D790
Impact		
Notched Izod Impact (73°F, 0.125 in)	3.0 ft-lb/in	D256
Thermal		
DTUL @ 264 psi – Unannealed (0.125 in)	168°F	D648
Mold Shrinkage		
Linear Flow	.005 – .008 in/in	D955
UL Rating	V0 (1.5 mm); V-0, 5VA (3.0mm)	UL94

Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	2.0 – 4.0 hrs at 170 – 190°F
Suggested Max Moisture	0.15%
Rear Temperature	300 – 360°F
Middle Temperature	350 – 400°F
Front Temperature	375 – 450°F
Nozzle Temperature	375 – 450°F
Processing (Melt) Temperature	375 – 450°F
Mold Temperature	120 – 170°F
Back Pressure	25 – 100 psi
Screw Speed	25 – 75 RPM