



GRADE: RE-ABSRC-GP002

Molding Grade General Purpose ABS
Including 50% Pre-consumer Validated Recycled Content Materials

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
Mechanical		
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
Impact		
Notched Izod Impact (73°F, 0.125 in)	3.5 ft-lb/in	D256
Thermal		
DTUL @ 264 psi – Unannealed (0.125 in)	170°F	D648
Mold Shrinkage		
Linear Flow	.005 – .008 in/in	D955
UL Rating	HB (1.5 mm)	UL94

Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	2.0 – 4.0 hrs at 180 – 200°F
Suggested Max Moisture	0.15%
Rear Temperature	370 – 425°F
Middle Temperature	400 – 450°F
Front Temperature	425 – 475°F
Nozzle Temperature	425 – 525°F
Processing (Melt) Temperature	425 – 525°F
Mold Temperature	120 – 170°F
Back Pressure	25 – 100 psi
Screw Speed	25 – 75 RPM