

Technical Data Sheet

Ronfalin ABS 1324 A FC

Acrylonitrile Butadiene Styrene
LyondellBasell Industries
Engineering Plastics

Product Description

Medium impact standard ABS grade, antistatic, suitable for food contact applications. (Former name: POLYMAN® (ABS) M/MI A K1452)

General

Features	• Antistatic	• Medium Impact Resistance
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• ABS	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.06 g/cm ³	1.06 g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (220°C/10.0 Kg)	25 cm ³ /10min	25 cm ³ /10min	ISO 1133

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	377000 psi	2600 MPa	ISO 527-1/1A/1
Tensile Stress (Yield)	7250 psi	50.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	3.0 %	3.0 %	ISO 527-2/1A/50

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	3.3 ft·lb/in ²	7.0 kJ/m ²	
73°F (23°C)	6.7 ft·lb/in ²	14 kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	28 ft·lb/in ²	58 kJ/m ²	
73°F (23°C)	43 ft·lb/in ²	91 kJ/m ²	

Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Ball Indentation Hardness (H 358/30)	17400 psi	120 MPa	ISO 2039-1

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	190 °F	88.0 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	171 °F	77.0 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	201 °F	94.0 °C	ISO 306/B50
--	217 °F	103 °C	ISO 306/A50

Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 In (2.00 Mm)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 In (2.00 Mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flammability Classification			IEC 60695-11-10, -20
0.06 In (1.5 Mm)	HB	HB	
0.12 In (3.0 Mm)	HB	HB	
Glow Wire Flammability Index			IEC 60695-2-12
0.06 In (1.5 Mm)	1250 °F	675 °C	
0.12 In (3.0 Mm)	1250 °F	675 °C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.06 In (1.5 Mm)	1290 °F	700 °C	
0.12 In (3.0 Mm)	1290 °F	700 °C	

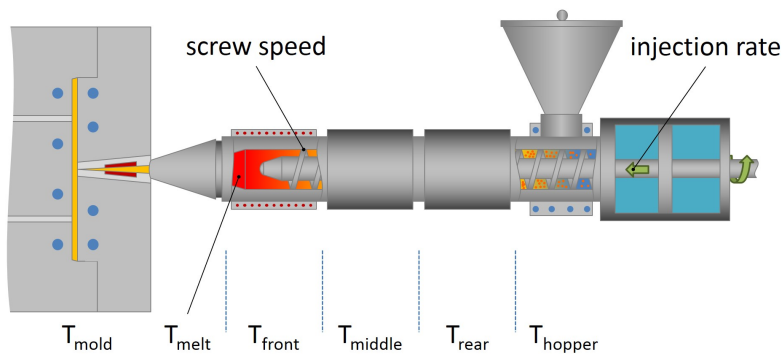
Additional Information

1.) Not for use in medical or pharmaceutical applications

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Processing (Melt) Temp	446 to 482 °F	230 to 250 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Notes

These are typical property values not to be construed as specification limits.