Technical Data Sheet

Ronfalin ABS 1344 A GRY68870

Acrylonitrile Butadiene Styrene

Product Description

High impact grade (Former name: RONFALIN ABS RT54)

Processing Method	Injection Molding
Attribute	Medium Impact Resistance

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (220 °C/10.0 kg)	21	cm³/10 min	ISO 1133
Density, (Method A)	1.04	g/cm³	ISO 1183
Mechanical			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	43.0	MPa	ISO 527-2
Tensile Strain at Yield, (Type 1A, 50 mm/min)	2.4	%	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	2300	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	21	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	11	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	No Break		ISO 179
Hardness			
Ball Indentation Hardness, (H 358/30)	104	MPa	ISO 2039-1
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	96.0	°C	ISO 306
(A (10N), 50 °C/h)	105	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	87.0	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	74.0	°C	ISO 75-2/A
Electrical			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Comparative Tracking Index (CTI)	600	V	IEC 60112
Surface Resistivity	>1.0E+15	ohm	IEC 60093
Flammable			

Burning Rate			
(2.00 mm)	36	mm/min	ISO 3795
(2.00 mm)	36	mm/min	FMVSS 302
Glow Wire Flammability Index			
(1.5 mm)	650	°C	IEC 60695-2-12
(3.0 mm)	650	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			
(1.5 mm)	675	°C	IEC 60695-2-13
(3.0 mm)	675	°C	IEC 60695-2-13
UL Information			
Flammability Classification			
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.0 to 0.10	%
Screw Speed	500	mm/sec
Processing (Melt) Temp	230 to 260	°C
Front Temperature	230 to 260	°C
Hopper Temperature	50	°C
Middle Temperature	205 to 235	°C
Rear Temperature	180 to 210	°C
Back Pressure	5.00 to 15.0	MPa
Mold Temperature	40 to 80	°C
Cushion	2.00 to 5.00	mm
Drying Time, Maximum	12	hr