

Technical Data Sheet

# Ronfalin ABS 1354 PG

Acrylonitrile Butadiene Styrene  
 LyondellBasell Industries  
 Engineering Plastics

**Product Description**

ABS compound, suitable for electroplating.

**General**

Features	• Good Flow	• Good Impact Resistance	• Platable
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• ABS		

**Physical**

	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.03 g/cm <sup>3</sup>	1.03 g/cm <sup>3</sup>	ISO 1183/A
Melt Volume-Flow Rate (MVR) (220°C/10.0 Kg)	25 cm <sup>3</sup> /10min	25 cm <sup>3</sup> /10min	ISO 1133

**Mechanical**

	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	319000 psi	2200 MPa	ISO 527-1/1A/1
Tensile Stress (Yield)	6090 psi	42.0 MPa	ISO 527-2/1A/50
Tensile Strain			ISO 527-2/1A/50
Yield	2.5 %	2.5 %	
Break	> 16 %	> 16 %	
Flexural Modulus	312000 psi	2150 MPa	ISO 178
Flexural Stress	8850 psi	61.0 MPa	ISO 178

**Impact**

	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	7.1 ft·lb/in <sup>2</sup>	15 kJ/m <sup>2</sup>	
73°F (23°C)	11 ft·lb/in <sup>2</sup>	24 kJ/m <sup>2</sup>	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	70 ft·lb/in <sup>2</sup>	150 kJ/m <sup>2</sup>	
73°F (23°C)	No Break	No Break	

**Hardness**

	Nominal Value (English)	Nominal Value (SI)	Test Method
Ball Indentation Hardness (H 358/30)	12900 psi	89.0 MPa	ISO 2039-1

**Thermal**

	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	207 °F	97.0 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	203 °F	95.0 °C	ISO 75-2/Af
Vicat Softening Temperature	199 °F	93.0 °C	ISO 306/B50

**Electrical**

	Nominal Value (English)	Nominal Value (SI)	Test Method
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 62631-3-2
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Comparative Tracking Index (Solution A)	600 V	600 V	IEC 60112

**Flammability**

	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 In (2.00 Mm)	2.4 in/min	60 mm/min	ISO 3795
0.0787 In (2.00 Mm)	2.4 in/min	60 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 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	

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**Additional Information**

- 1.) Not for use in food contact applications
- 2.) 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.