Technical Data Sheet

Ronfalin ABS 1621 U GRM60725

Acrylonitrile Butadiene Styrene

Product Description

Very high heat grade; applications include heavy duty appliances, power tools and automotive parts. (Former name: RONFALIN 205H)

Processing Method	Injection Molding
Resin ID	ABS

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (220 °C/10.0 kg)	6.0	cm³/10 min	ISO 1133
Density, (Method A)	1.05	g/cm³	ISO 1183
Mechanical			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	58.0	MPa	ISO 527-2
Tensile Strain at Break, (Type 1A, 5 mm/min)	9.0	%	ISO 527-2
Tensile Strain at Yield, (Type 1A, 50 mm/min)	3.1	%	ISO 527-2
Tensile Modulus	2700	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	12	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	7.0	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(-30 °C)	No Break		ISO 179
(23 °C)	No Break		ISO 179
Hardness			
Ball Indentation Hardness, (H 358/30)	114	MPa	ISO 2039-1
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	112	°C	ISO 306
(A (10N), 50 °C/h)	122	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	110	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	102	°C	ISO 75-2/A
Electrical			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Comparative Tracking Index (CTI), (Solution A)	600	V	IEC 60112
Surface Resistivity	>1.0E+15	ohm	IEC 60093
Flammable			

Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302
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
Processing (Melt) Temp	230 to 250	°C
Mold Temperature	40 to 80	°C