

Technical Data Sheet

Polyflam RMMK 125

Acrylonitrile Butadiene Styrene + PA
 LyondellBasell Industries
 Engineering Plastics

Product Description

Flame-retardant ABS/PA blend; without PBDE; high stress crack resistance

General

Features	<ul style="list-style-type: none"> Flame Retardant High ESCR (Stress Crack Resist.)
UL File Number	<ul style="list-style-type: none"> E86615
Processing Method	<ul style="list-style-type: none"> Injection Molding

Physical	Dry	Conditioned	Unit	Test Method
Density	1.30	--	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (250°C/5.0 Kg)	12	--	cm ³ /10min	ISO 1133

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	363000 (2500)	136000 (940)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Yield)	7540 (52.0)	4210 (29.0)	psi (MPa)	ISO 527-2/1A/50
Tensile Strain (Yield)	3.0	16	%	ISO 527-2/1A/50

Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	4.3 (9.0)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	5.7 (12)	10 (21)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	No Break	No Break		
73°F (23°C)	No Break	No Break		

Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	235 (113)	--	°F (°C)	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	140 (60.0)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	313 (156)	--	°F (°C)	ISO 306/B50
--	374 (190)	--	°F (°C)	ISO 306/A50
Ball Pressure Test (257°F (125°C))	Pass	--		IEC 60695-10-2
RTI Elec				UL 746B
0.06 In (1.5 Mm)	140 (60.0)	--	°F (°C)	
0.12 In (3.0 Mm)	140 (60.0)	--	°F (°C)	

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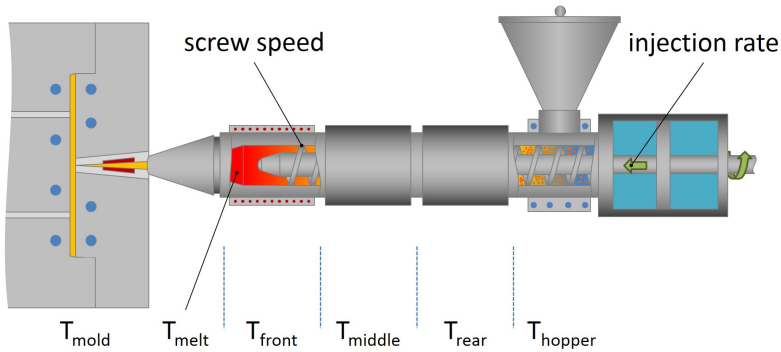
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Thermal	Dry	Conditioned	Unit	Test Method
RTI Imp				UL 746B
0.06 In (1.5 Mm)	140 (60.0)	--	°F (°C)	
0.12 In (3.0 Mm)	140 (60.0)	--	°F (°C)	
RTI Str				UL 746B
0.06 In (1.5 Mm)	140 (60.0)	--	°F (°C)	
0.12 In (3.0 Mm)	140 (60.0)	--	°F (°C)	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	> 1.0E+15	--	ohms	IEC 60093
Volume Resistivity	> 1.0E+13	--	ohms-m	IEC 62631-3-1
Comparative Tracking Index	200	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 In (2.00 Mm), Self-extinguishing	0.0	--	in/min (mm/min)	FMVSS 302
0.0787 In (2.00 Mm), Self-extinguishing	0.0	--	in/min (mm/min)	ISO 3795
Flame Rating				UL 94 IEC 60695-11-10, -20
0.06 In (1.5 Mm)	V-0	--		
0.12 In (3.0 Mm)	V-0	--		
0.08 In (2.0 Mm)	5VA	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.030 In (0.75 Mm)	1760 (960)	--	°F (°C)	
0.06 In (1.5 Mm)	1760 (960)	--	°F (°C)	
0.12 In (3.0 Mm)	1760 (960)	--	°F (°C)	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.06 In (1.5 Mm)	1380 (750)	--	°F (°C)	
0.12 In (3.0 Mm)	1380 (750)	--	°F (°C)	
Oxygen Index	31	--	%	ISO 4589-2

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Injection	Dry (English)	Dry (SI)
Drying Temperature	158 to 176 °F	70 to 80 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	464 to 500 °F	240 to 260 °C
Mold Temperature	104 to 176 °F	40 to 80 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	725 to 1450 psi	5.00 to 10.0 MPa
Screw Speed	< 591 in/min	< 15 m/min

Injection Notes

Mould surface contacting melt should be of non-corrosive steel (content of chrome > 12%)

Notes

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