



**Product Data Sheet &  
General Processing Conditions**

**PermaStat® 600 Nat/Clear  
Acrylonitrile Butadiene Styrene  
(ABS)  
ESD Protection  
Permanently Anti-static  
Transparent Grade  
Violet Tint**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.11	1.11	D 792
Melt Flow Rate @ 230 °C, / 3.8 kg	13.00 - 17.00 g/10 min	13.00 - 17.00 g/10 min	D 1238
Molding Shrinkage 1/8 in (3.2 mm) section	0.0050 - 0.0070 in/in	0.50 - 0.70 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	3.5 ft-lbs/in	187 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	5600 psi	39 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.27 x 10 <sup>6</sup> psi	1862 MPa	D 638
Flexural Strength	8800 psi	61 MPa	D 790
Flexural Modulus	0.29 x 10 <sup>6</sup> psi	2000 MPa	D 790

**ELECTRICAL**

Volume Resistivity	< 1E10 ohm.cm	< 1E10 ohm.cm	D 257
Surface Resistivity	< 1E11 ohm/sq	< 1E11 ohm/sq	D 257
Static Decay	< 2.00 s	< 2.00 s	FTMS101C 4046.1

**THERMAL**

Deflection Temperature @ 264 psi (1820 kPa)	163 °F	73 °C	D 648
@ 66 psi (455 kPa)	176 °F	80 °C	D 648
Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635

**PROPERTY NOTES**

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

\* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

\*\* Values per RTP Company testing.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	390 - 460 °F	199 - 238 °C
Mold Temperature	120 - 200 °F	49 - 93 °C
Drying	2 hrs @ 180 °F	2 hrs @ 82 °C
Moisture Content	0.10 %	0.10 %
Dew Point	0 °F	-18 °C

**PROCESSING NOTES**

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Do not exceed 520 °F (270 °C) melt temperature.  
Desiccant Type Dryer Required.