



**Product Data Sheet &
General Processing Conditions**

**RTP 600 GB 20
Acrylonitrile Butadiene Styrene
(ABS)
Glass Bead**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | English | SI Metric | ASTM TEST |
|--|-----------------------|------------------|------------------|
| Primary Additive | 20 % | 20 % | |
| Specific Gravity | 1.17 | 1.17 | D 792 |
| Molding Shrinkage 1/8 in (3.2 mm) section | 0.0040 - 0.0080 in/in | 0.40 - 0.80 % | D 955 |

MECHANICAL

| | | | |
|--|----------------------------|----------|--------|
| Impact Strength, Izod notched 1/8 in (3.2 mm) section | 1.3 ft-lbs/in | 69 J/m | D 256 |
| unnotched 1/8 in (3.2 mm) section | 7.0 ft-lbs/in | 374 J/m | D 4812 |
| Tensile Strength | 4800 psi | 33 MPa | D 638 |
| Tensile Elongation | > 10.0 % | > 10.0 % | D 638 |
| Tensile Modulus | 0.40 x 10 ⁶ psi | 2758 MPa | D 638 |
| Flexural Strength | 9200 psi | 63 MPa | D 790 |
| Flexural Modulus | 0.40 x 10 ⁶ psi | 2758 MPa | D 790 |

THERMAL

| | | | |
|--|--------------|-------------|-------|
| 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

| | English | SI Metric |
|--------------------|-------------------|------------------|
| Injection Pressure | 10000 - 15000 psi | 69 - 103 MPa |
| Melt Temperature | 400 - 460 °F | 204 - 238 °C |
| Mold Temperature | 145 - 185 °F | 63 - 85 °C |
| Drying | 2 hrs @ 180 °F | 2 hrs @ 82 °C |
| Moisture Content | 0.10 % | 0.10 % |
| Dew Point | 0 °F | -18 °C |

PROCESSING NOTES

Desiccant Type Dryer Required.