




**Product Data Sheet &  
General Processing Conditions**

**RTP 600 SI 2 HB**  
**Acrylonitrile Butadiene Styrene**  
**(ABS)**  
**Silicone Lubricated**  
**UL94 HB**  


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

| <b>PERMANENCE</b>                            | <b>English</b>        | <b>SI Metric</b> | <b>ASTM TEST</b> |
|----------------------------------------------|-----------------------|------------------|------------------|
| Primary Additive                             | 2 %                   | 2 %              |                  |
| Specific Gravity                             | 1.05                  | 1.05             | D 792            |
| Molding Shrinkage<br>1/8 in (3.2 mm) section | 0.0060 - 0.0080 in/in | 0.60 - 0.80 %    | D 955            |

**MECHANICAL**

|                                                          |                            |          |        |
|----------------------------------------------------------|----------------------------|----------|--------|
| Impact Strength, Izod<br>notched 1/8 in (3.2 mm) section | 5.0 ft-lbs/in              | 267 J/m  | D 256  |
| unnotched 1/8 in (3.2 mm) section                        | 30.0 ft-lbs/in             | 1602 J/m | D 4812 |
| Tensile Strength                                         | 6200 psi                   | 43 MPa   | D 638  |
| Tensile Elongation                                       | > 10.0 %                   | > 10.0 % | D 638  |
| Tensile Modulus                                          | 0.33 x 10 <sup>6</sup> psi | 2275 MPa | D 638  |
| Flexural Strength                                        | 11000 psi                  | 76 MPa   | D 790  |
| Flexural Modulus                                         | 0.37 x 10 <sup>6</sup> psi | 2551 MPa | D 790  |

**THERMAL**

|                                                |              |             |       |
|------------------------------------------------|--------------|-------------|-------|
| Deflection Temperature<br>@ 264 psi (1820 kPa) | 210 °F       | 99 °C       | D 648 |
| Ignition Resistance*<br>Flammability           | HB @ 1/16 in | HB @ 1.5 mm | UL94  |

**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.

**GENERAL PROCESSING FOR INJECTION MOLDING**

|                    | <b>English</b>    | <b>SI Metric</b> |
|--------------------|-------------------|------------------|
| 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.