



**Product Data Sheet &
General Processing Conditions**

**RTP 600
Acrylonitrile Butadiene Styrene (ABS)**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE **STANDARD**

Density	1.04 g/cm ³	ISO 1183
Shrinkage, 4 mm Thickness		
Flow direction	0.30 - 0.70 %	ASTM D 955

MECHANICAL

Impact Strength, Izod		
Notched, 4 mm thickness	20 kJ/m ²	ISO 180/1A
Unnotched, 4 mm thickness	150 kJ/m ²	ISO 180/1U
Tensile Strength	45 MPa	ISO 527
Tensile Elongation	8.0 - 15.0 %	ISO 527
Tensile Modulus	2400 MPa	ISO 527
Flexural Strength	75 MPa	ISO 178
Flexural Modulus	2300 MPa	ISO 178

THERMAL

Heat Deflection Temperature		
@ 1.80 MPa	82 °C	ISO 75
Ignition Resistance*		
Flammability**	HB @ 1.5 mm	ISO 1210

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

Injection Pressure	70 - 105 MPa
Injection Pressure	680 - 1030 bar
Melt Temperature	205 - 235 °C
Mold Temperature	60 - 85 °C
Drying	2 hrs @ 80 °C
Moisture Content	0.10 %
Dew Point	-25 °C

PROCESSING NOTES

Desiccant Type Dryer Required.