



**Product Data Sheet &  
General Processing Conditions**

**RTP 699 X 113386 B  
Acrylonitrile Butadiene Styrene  
(ABS)  
LDS Platable**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.17	1.17	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0070 in/in	0.70 %	D 955
<b>MECHANICAL</b>			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	2.5 ft-lbs/in	133 J/m	D 256
unnotched 1/8 in (3.2 mm) section	25.0 ft-lbs/in	1335 J/m	D 4812
Tensile Strength	5000 psi	34 MPa	D 638
Tensile Elongation	6.0 - 10.0 %	6.0 - 10.0 %	D 638
Tensile Modulus	0.35 x 10 <sup>6</sup> psi	2413 MPa	D 638
Flexural Strength	9000 psi	62 MPa	D 790
Flexural Modulus	0.33 x 10 <sup>6</sup> psi	2275 MPa	D 790
<b>ELECTRICAL</b>			
Dielectric Constant, 1 MHz, Dry	3.0	3.0	D 150
Dissipation Factor, 1 MHz, Dry	0.0150	0.0150	D 150
<b>THERMAL</b>			
Deflection Temperature @ 66 psi (455 kPa)	205 °F	96 °C	D 648
Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635
Coefficient of Linear Thermal Expansion Flow Direction	3.7 x 10 <sup>-5</sup> /°F	6.7 x 10 <sup>-5</sup> /°C	E 831
Transverse Direction	5.5 x 10 <sup>-5</sup> /°F	10.0 x 10 <sup>-5</sup> /°C	E 831

**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	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.