

Technical Data Sheet

Ronfalin ABS 1344 A GRY68870



Acrylonitrile Butadiene Styrene

Product Description

High impact grade (Former name: RONFALIN ABS RT54)

Regulatory Status

For regulatory compliance information, see *Ronfalin* ABS 1344 A GRY68870 [Product Stewardship Bulletin \(PSB\)](#) and [Safety Data Sheet \(SDS\)](#).

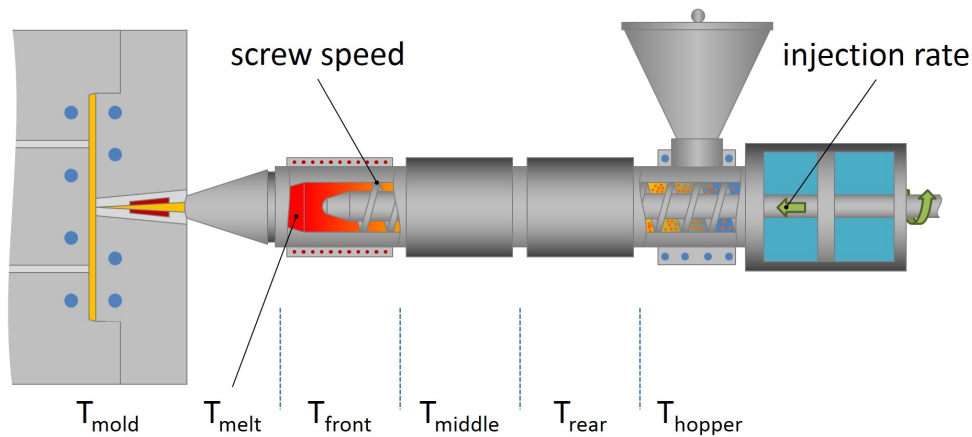
Status	Commercial: Active
Availability	Africa-Middle East; Asia-Pacific; Europe; Latin America; North America
Processing Method	Injection Molding
Attribute	Medium Impact Resistance

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (220 °C/10.0 kg)	21	cm ³ /10 min	ISO 1133
Density, (Method A)	1.04	g/cm ³	ISO 1183
Mechanical			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	43.0	MPa	ISO 527-2
Tensile Strain at Yield, (Type 1A, 50 mm/min)	2.4	%	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	2300	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	21	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	11	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	No Break		ISO 179
Hardness			
Ball Indentation Hardness, (H 358/30)	104	MPa	ISO 2039-1
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	96.0	°C	ISO 306
(A (10N), 50 °C/h)	105	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	87.0	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	74.0	°C	ISO 75-2/A
Electrical			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Comparative Tracking Index (CTI)	600	V	IEC 60112
Surface Resistivity	>1.0E+15	ohm	IEC 60093
Flammable			

Burning Rate			
(2.00 mm)	36	mm/min	ISO 3795
(2.00 mm)	36	mm/min	FMVSS 302
Glow Wire Flammability Index			
(1.5 mm)	650	°C	IEC 60695-2-12
(3.0 mm)	650	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			
(1.5 mm)	675	°C	IEC 60695-2-13
(3.0 mm)	675	°C	IEC 60695-2-13

UL Information

Flammability Classification			
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20



Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.0 to 0.10	%
Screw Speed	500	mm/sec
Processing (Melt) Temp	230 to 260	°C
Front Temperature	230 to 260	°C
Hopper Temperature	50	°C
Middle Temperature	205 to 235	°C
Rear Temperature	180 to 210	°C
Back Pressure	5.00 to 15.0	MPa
Mold Temperature	40 to 80	°C
Cushion	2.00 to 5.00	mm
Drying Time, Maximum	12	hr

Notes

These are typical property values not to be construed as specification limits.

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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