

RONFALIN® ABS 1336 FC

Acrylonitrile Butadiene Styrene

A. Schulman Europe

Message:

General purpose ABS Compound, good flow. Suitable for food contact use.

General Information			
Features	Good liquidity		
Processing Method	Injection molding		
Resin ID (ISO 1043)	ABS		
Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	32.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	124	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ISO 527-2/1A/1
Tensile Stress			ISO 527-2/1A/50
Yield	50.0	MPa	ISO 527-2/1A/50
Fracture	39.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	3.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	16	%	ISO 527-2/1A/50
Flexural Modulus ¹	2800	MPa	ISO 178
Flexural Stress ² (4.7% strain)	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	8.0	kJ/m ²	ISO 179/1eA
23°C	17	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	90	kJ/m ²	ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	89.0	°C	ISO 75-2/Bf
1.8 MPa, not annealed	77.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	103	°C	ISO 306/A50
--	97.0	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method

Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flammability Classification			IEC 60695-11-10, -20
1.6 mm	HB		IEC 60695-11-10, -20
3.2 mm	HB		IEC 60695-11-10, -20
Glow Wire Ignition Temperature			IEC 60695-2-13
1.5 mm	700	°C	IEC 60695-2-13
3.0 mm	700	°C	IEC 60695-2-13

Additional Information

- 1.)
Not for use in medical or pharmaceutical applications

Injection	Nominal Value	Unit
Drying Temperature	80	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Regrind	30	%
Processing (Melt) Temp	230 - 250	°C
Mold Temperature	40 - 80	°C

NOTE

- 2.0 mm/min
- 2.0 mm/min

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