

RONFALIN® ABS 1328 A

Acrylonitrile Butadiene Styrene

A. Schulman Europe

Message:

General purpose ABS Compound, high flow, antistatic

General Information			
Features	Good liquidity		
Processing Method	Injection molding		
Resin ID (ISO 1043)	ABS		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	42.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	128	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)	3.1	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	15	%	ISO 527-2/1A/50
Flexural Modulus ¹	2900	MPa	ISO 178
Flexural Stress ² (4.7% strain)	82.0	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	12	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	79	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	92.0	°C	ISO 75-2/Bf
1.8 MPa, not annealed	82.0	°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 food contact applications2.)
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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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