



## Product Data Sheet & General Processing Conditions

### RTP 600 Acrylonitrile Butadiene Styrene (ABS)

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

PERMANENCE	STANDARD
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Density	1.04 g/cm <sup>3</sup>	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 <sup>2</sup>	ISO 180/1A
Unnotched, 4 mm thickness	150 kJ/m <sup>2</sup>	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.

5 Jul 2012 CJH

This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all

molded articles will have the same properties as those listed.

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