Product Data Sheet &
General Processing Conditions

PermaStat® 600 Nat/Clear
Acrylonitrile Butadiene Styrene (ABS)
ESD Protection
Permanently Anti-static
Transparent Grade
Violet Tint

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.11	1.11	D 792
Melt Flow Rate			
@ 230 °C, / 3.8 kg	13.00 - 17.00 g/10 min	13.00 - 17.00 g/10 min	D 1238
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0050 - 0.0070 in/in	0.50 - 0.70 %	D 955
MECHANICAL			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	3.5 ft-lbs/in	187 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	5600 psi	39 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.27 x 10^6 psi	1862 MPa	D 638
Flexural Strength	8800 psi	61 MPa	D 790
Flexural Modulus	0.29 x 10^6 psi	2000 MPa	D 790
ELECTRICAL			
Volume Resistivity	< 1E10 ohm.cm	< 1E10 ohm.cm	D 257
Surface Resistivity	< 1E11 ohm/sq	< 1E11 ohm/sq	D 257
Static Decay	< 2.00 s	< 2.00 s	FTMS101C 4046.1
THERMAL			
Deflection Temperature			
@ 264 psi (1820 kPa)	163 °F	73 °C	D 648
@ 66 psi (455 kPa)	176 °F	80 °C	D 648
Ignition Resistance*			
Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635

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

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	390 - 460 °F	199 - 238 °C
Mold Temperature	120 - 200 °F	49 - 93 °C
Drying	2 hrs @ 180 °F	2 hrs @ 82 °C
Moisture Content	0.10 %	0.10 %
Dew Point	0 °F	-18 °C

PROCESSING NOTES

Do not exceed 520 °F (270 °C) melt temperature.
Desiccant Type Dryer Required.

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