

Technical Data Sheet



Ronfalin ABS 1344

Acrylonitrile Butadiene Styrene
LyondellBasell Industries
Engineering Plastics

Product Description

High impact grade (Former name: RONFALIN ABS RT54)

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Medium Impact Resistance		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.04 g/cm ³	1.04 g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	21 cm ³ /10min	21 cm ³ /10min	ISO 1133
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	334000 psi	2300 MPa	ISO 527-1/1A/1
Tensile Stress (Yield)	6240 psi	43.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	2.4 %	2.4 %	ISO 527-2/1A/50
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	5.2 ft·lb/in ²	11 kJ/m ²	
73°F (23°C)	10 ft·lb/in ²	21 kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	No Break	No Break	
73°F (23°C)	No Break	No Break	
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Ball Indentation Hardness (H 358/30)	15100 psi	104 MPa	ISO 2039-1
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			
66 psi (0.45 MPa), Unannealed	189 °F	87.0 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	165 °F	74.0 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	205 °F	96.0 °C	ISO 306/B50
--	221 °F	105 °C	ISO 306/A50
Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Comparative Tracking Index	600 V	600 V	IEC 60112
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	1.4 in/min	36 mm/min	ISO 3795
0.0787 in (2.00 mm)	1.4 in/min	36 mm/min	FMVSS 302
Flammability Classification			IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	
Glow Wire Flammability Index			IEC 60695-2-12
0.06 in (1.5 mm)	1200 °F	650 °C	
0.12 in (3.0 mm)	1200 °F	650 °C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.06 in (1.5 mm)	1250 °F	675 °C	
0.12 in (3.0 mm)	1250 °F	675 °C	

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Additional Information

ABS can normally be left in the cylinder. If in doubt purge with polyolefin
Finishing

"ABS is suitable for machining. Varnishing, printing, gluing and embossing can
be carried out using commercially available products.
Electroplating is affected by rubber type and content as well moulded in stress
and orientation. Use of special electroplating types is recommended for
optimum adhesion.
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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Drying Time, Maximum	12 hr	12 hr
Suggested Max Moisture	0.00 to 0.10 %	0.00 to 0.10 %
Hopper Temperature	122 °F	50 °C
Rear Temperature	356 to 410 °F	180 to 210 °C
Middle Temperature	401 to 455 °F	205 to 235 °C
Front Temperature	446 to 500 °F	230 to 260 °C
Processing (Melt) Temp	446 to 500 °F	230 to 260 °C
Mold Temperature	104 to 176 °F	40 to 80 °C
Back Pressure	725 to 2180 psi	5.00 to 15.0 MPa
Cushion	0.0787 to 0.197 in	2.00 to 5.00 mm
Screw Speed	1.6 ft/sec	30 m/min

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.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

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

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