

Technical Data Sheet

Ronfalin ABS 1354 PG

Acrylonitrile Butadiene Styrene
LyondellBasell Industries
Engineering Plastics

Product Description

ABS compound, suitable for electroplating.

General

Features	• Good Flow	• Good Impact Resistance	• Platable
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• ABS		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.03 g/cm ³	1.03 g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (220°C/10.0 Kg)	25 cm ³ /10min	25 cm ³ /10min	ISO 1133

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	319000 psi	2200 MPa	ISO 527-1/1A/1
Tensile Stress (Yield)	6090 psi	42.0 MPa	ISO 527-2/1A/50
Tensile Strain			ISO 527-2/1A/50
Yield	2.5 %	2.5 %	
Break	> 16 %	> 16 %	
Flexural Modulus	312000 psi	2150 MPa	ISO 178
Flexural Stress	8850 psi	61.0 MPa	ISO 178

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	7.1 ft·lb/in ²	15 kJ/m ²	
73°F (23°C)	11 ft·lb/in ²	24 kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	70 ft·lb/in ²	150 kJ/m ²	
73°F (23°C)	No Break	No Break	

Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Ball Indentation Hardness (H 358/30)	12900 psi	89.0 MPa	ISO 2039-1

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	207 °F	97.0 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	203 °F	95.0 °C	ISO 75-2/Af
Vicat Softening Temperature	199 °F	93.0 °C	ISO 306/B50

Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 62631-3-2
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Comparative Tracking Index (Solution A)	600 V	600 V	IEC 60112

Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 In (2.00 Mm)	2.4 in/min	60 mm/min	ISO 3795
0.0787 In (2.00 Mm)	2.4 in/min	60 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 Ignition Temperature			IEC 60695-2-13
0.06 In (1.5 Mm)	1290 °F	700 °C	
0.12 In (3.0 Mm)	1290 °F	700 °C	

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Additional Information

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

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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
Processing (Melt) Temp	446 to 482 °F	230 to 250 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Notes

These are typical property values not to be construed as specification limits.