

Technical Data Sheet

RONFALIN® MABS 2224

Methyl Methacrylate / ABS
Engineering Plastics

Product Description

High flow, high impact, transparent ABS grade. (Former name: POLYLUX MABS C12 KU)

General

Processing Method	• Injection Molding
Resin ID (ISO 1043)	• MABS

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.09 g/cm ³	1.09 g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	24 cm ³ /10min	24 cm ³ /10min	ISO 1133
Molding Shrinkage	0.40 to 0.70 %	0.40 to 0.70 %	ISO 294-4
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	247000 psi	1700 MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	5950 psi	41.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	3.5 %	3.5 %	ISO 527-2/1A/50
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength (73°F (23°C))	6.2 ft·lb/in ²	13 kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength 73°F (23°C)	42 ft·lb/in ²	88 kJ/m ²	ISO 179/1eU
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature 264 psi (1.8 MPa), Unannealed	163 °F	73.0 °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 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)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flammability Classification 0.06 in (1.5 mm)	HB	HB	IEC 60695-11-10, -20
0.12 in (3.0 mm)	HB	HB	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	158 °F	70 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Processing (Melt) Temp	392 to 464 °F	200 to 240 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Notes

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