

Optilac RP350SE

The Materials Group - *Acrylonitrile Butadiene Styrene*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Features	• Good Surface Finish
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.04		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	6.5E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	6100	psi	ASTM D638
Flexural Modulus	321000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	4.0	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	190	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	190 to 200	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Processing (Melt) Temp	425 to 525	°F

Injection Notes

Exact processing temp will vary w/ part. Starting mid-lower range is typical. Contact TMG for on-site technical support.

Notes

¹ Typical properties: these are not to be construed as specifications.

