

Toyolac® 600-309

Acrylonitrile Butadiene Styrene

Toray Resin Company

Message:

Toyolac® 600-309 is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by extrusion and is available in Asia Pacific, Europe, or North America. Primary characteristic: flame rated.

General Information			
Processing Method	Extrusion		
Part Marking Code	>ABS<		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.04	g/cm ³	ASTM D792
23°C	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	12	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.60	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	106		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	45.0	MPa	ASTM D638
23°C	47.0	MPa	ISO 527-2
Tensile Elongation			
Break	50	%	ASTM D638
Break, 23°C	14	%	ISO 527-2
Flexural Modulus			
--	2060	MPa	ASTM D790
23°C	2080	MPa	ISO 178
Flexural Strength			
--	65.0	MPa	ASTM D790
23°C	69.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	22	kJ/m ²	ISO 179
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	460	J/m	
23°C, 12.7 mm	280	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 6.40 mm	86.0	°C	ASTM D648
1.8 MPa, Unannealed	82.0	°C	ISO 75-2/A

Vicat Softening Temperature	90.0 to 95.0	°C
Flammability	Nominal Value	Test Method
Flame Rating	HB	UL 94

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