

RONFALIN® 1344 FC

Acrylonitrile Butadiene Styrene

A. Schulman Europe

Message:

Medium impact ABS grade

General Information			
Features	Medium impact resistance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	21.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	104	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	43.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	2.4	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	11	kJ/m ²	ISO 179/1eA
23°C	21	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	87.0	°C	ISO 75-2/Bf
1.8 MPa, not annealed	74.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	105	°C	ISO 306/A50
--	96.0	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+13	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Burning Rate (2.00 mm)	36	mm/min	ISO 3795
Flammability Classification			IEC 60695-11-10, -20
1.50 mm	HB		IEC 60695-11-10, -20

3.00 mm	HB		IEC 60695-11-10, -20
Glow Wire Flammability Index			IEC 60695-2-12
1.50 mm	650	°C	IEC 60695-2-12
3.00 mm	650	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
1.50 mm	675	°C	IEC 60695-2-13
3.00 mm	675	°C	IEC 60695-2-13

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 as moulded in stress and orientation. Use of special electroplating types is recommended for optimum adhesion."

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	2.0 - 4.0	hr
Drying Time, Maximum	12	hr
Suggested Max Moisture	0.0 - 0.10	%
Suggested Max Re grind	30	%
Hopper Temperature	50.0	°C
Rear Temperature	180 - 210	°C
Middle Temperature	205 - 235	°C
Front Temperature	230 - 260	°C
Processing (Melt) Temp	230 - 260	°C
Mold Temperature	30.0 - 80.0	°C
Back Pressure	5.00 - 15.0	MPa
Cushion	2.00 - 5.00	mm
Screw Speed	500	mm/sec

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