

Technical Data Sheet

Ronfalin ABS XG1138 BLK 2.0010

Acrylonitrile Butadiene Styrene

Product Description

Flame retardant ABS

Processing Method Injection Molding

Additive Flame Retardant

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (220 °C/10.0 kg)	30	g/10 min	ISO 1133
Density	1.2	g/cm ³	ISO 1183
Mechanical			
Tensile Stress at Yield	46	MPa	ISO 527-2
Tensile Strain at Yield	2.5	%	ISO 527-2
Tensile Modulus	2300	MPa	ISO 527-1
Flexural Stress	78	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched, (23 °C)	12	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched, (23 °C)	No Break		ISO 179
Hardness			
Ball Indentation Hardness	96	MPa	ISO 2039-1
Thermal			
Vicat Softening Temperature, (B (50N), 50 °C/h)	96.0	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa)	92	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa)	80	°C	ISO 75-2/A
Flammable			
Glow Wire Flammability Index	960	°C	IEC 60695-2-12
UL Information			
Flame Rating			
(1.5 mm)	V-0		UL 94
(3.0 mm)	V-0		UL 94

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	80	°C
Processing (Melt) Temp	200 to 240	°C
Injection Rate	Moderate	
Mold Temperature	40 to 80	°C
Injection Pressure	800 to 1500	MPa