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Product Data Sheet & General Processing Conditions

RTP 685 Acrylonitrile Butadiene Styrene (ABS) Carbon Fiber

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.18	1.18	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0005 - 0.0020 in/in	0.05 - 0.20 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.0 ft-lbs/in	53 J/m	D 256
unnotched 1/8 in (3.2 mm) section	5.5 ft-lbs/in	294 J/m	D 4812
Tensile Strength	17500 psi	121 MPa	D 638
Tensile Elongation	1.0 - 1.5 %	1.0 - 1.5 %	D 638
Tensile Modulus	2.70 x 10 ⁶ psi	18616 MPa	D 638
Flexural Strength	25500 psi	176 MPa	D 790
Flexural Modulus	2.30 x 10 ⁶ psi	15858 MPa	D 790

ELECTRICAL

Volume Resistivity	< 1E2 ohm.cm	< 1E2 ohm.cm	D 257
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THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	212 °F	100 °C	D 648
Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

** Values per RTP Company testing.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	400 - 460 °F	204 - 238 °C
Mold Temperature	145 - 185 °F	63 - 85 °C
Drying	2 hrs @ 180 °F	2 hrs @ 82 °C
Moisture Content	0.10 %	0.10 %
Dew Point	0 °F	-18 °C

PROCESSING NOTES

Desiccant Type Dryer Required.