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## Product Data Sheet & General Processing Conditions

### RTP 699 X 113386 B Acrylonitrile Butadiene Styrene (ABS) LDS Platable

#### PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE                                               | English                    | SI Metric                   | ASTM TEST |
|----------------------------------------------------------|----------------------------|-----------------------------|-----------|
| Specific Gravity                                         | 1.17                       | 1.17                        | D 792     |
| Molding Shrinkage<br>1/8 in (3.2 mm) section             | 0.0070 in/in               | 0.70 %                      | D 955     |
| <b>MECHANICAL</b>                                        |                            |                             |           |
| Impact Strength, Izod<br>notched 1/8 in (3.2 mm) section | 2.5 ft-lbs/in              | 133 J/m                     | D 256     |
| unnotched 1/8 in (3.2 mm) section                        | 25.0 ft-lbs/in             | 1335 J/m                    | D 4812    |
| Tensile Strength                                         | 5000 psi                   | 34 MPa                      | D 638     |
| Tensile Elongation                                       | 6.0 - 10.0 %               | 6.0 - 10.0 %                | D 638     |
| Tensile Modulus                                          | 0.35 x 10 <sup>6</sup> psi | 2413 MPa                    | D 638     |
| Flexural Strength                                        | 9000 psi                   | 62 MPa                      | D 790     |
| Flexural Modulus                                         | 0.33 x 10 <sup>6</sup> psi | 2275 MPa                    | D 790     |
| <b>ELECTRICAL</b>                                        |                            |                             |           |
| Dielectric Constant, 1 MHz, Dry                          | 3.0                        | 3.0                         | D 150     |
| Dissipation Factor, 1 MHz, Dry                           | 0.0150                     | 0.0150                      | D 150     |
| <b>THERMAL</b>                                           |                            |                             |           |
| Deflection Temperature<br>@ 66 psi (455 kPa)             | 205 °F                     | 96 °C                       | D 648     |
| Ignition Resistance*                                     |                            |                             |           |
| Flammability**                                           | HB @ 1/16 in               | HB @ 1.5 mm                 | D 635     |
| Coefficient of Linear Thermal Expansion                  |                            |                             |           |
| Flow Direction                                           | 3.7 x 10 <sup>-5</sup> /°F | 6.7 x 10 <sup>-5</sup> /°C  | E 831     |
| Transverse Direction                                     | 5.5 x 10 <sup>-5</sup> /°F | 10.0 x 10 <sup>-5</sup> /°C | E 831     |

#### 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.