



**OmniTech™**  
**ABS 24 HH**  
 High Heat Resistant ABS

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Melt Flow	g/10 min.	D1238	4	4
Specific Gravity		D792	1.05	1.05
<b>IMPACT</b>				
Izod Impact Resistance Notched 1/8" bar, 73 °F	ft.-lbs/in. (J/m)	D256	2	107
<b>MECHANICAL</b>				
Tensile Strength At Yield, 73 °F	psi (MPa)	D638	6,500	45
Tensile Elongation	%	D638	50	50
Flexural Modulus	psi (MPa)	D790	330,000	2,275
Flexural Strength	psi (MPa)	D790	10,500	72
<b>THERMAL</b>				
Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	225	107
1/8" bar, 264 psi	°F (°C)	D648	200	93
<b>FLAMMABILITY</b>				
Flame Resistance *Omni Internal Testing	.125"	UL94	HB*	HB*
<b>RECOMMENDED PROCESSING CONDITIONS</b>				
Drying Temperature			190 °F	
Drying Time			4 hrs. max.	
Maximum Moisture			0.02%	
Rear Zone(s)			400 to 480 °F	
Middle Zone(s)			420 to 500 °F	
Front Zone(s)			420 to 500 °F	
Nozzle			420 to 500 °F	
Mold Temperature			80 to 140 °F	
Melt Temperature			420 to 500 °F	
Back Pressure			50 to 100 psi	

Values are based on natural or black materials unless otherwise noted. Properties and values herein are based on laboratory test specimens and should not be used to establish minimum specification limits or fabricate tooling.

Omni does not guarantee the accuracy of this information or the suitability of this product in any given application or usage situation.