

Diamond Polymers ABS 3500ELG

Category : Polymer , Thermoplastic , ABS Polymer , Acrylonitrile Butadiene Styrene (ABS), Impact Grade, Molded

Material Notes:

Description: Injection Molding Grade, Medium Impact, Low Gloss
Information provided by Diamond Polymers, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Diamond-Polymers-ABS-3500ELG.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.06 g/cc	1.06 g/cc	ASTM D792
Linear Mold Shrinkage	0.0040 - 0.0060 cm/cm	0.0040 - 0.0060 in/in	ASTM D955
Melt Flow	2.3 g/10 min	2.3 g/10 min	Procedure A Condition G; ASTM D1238
	@Load 5.00 kg, Temperature 200 °C	@Load 11.0 lb, Temperature 392 °F	
	8.6 g/10 min	8.6 g/10 min	Procedure A Condition I; ASTM D1238
	@Load 3.80 kg, Temperature 230 °C	@Load 8.38 lb, Temperature 446 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	104	104	ASTM D785
Tensile Strength, Yield	40.0 MPa	5800 psi	chs 2 in/min; ASTM D638
Flexural Modulus	2.28 GPa	330 ksi	Tangent, chs 0.05 in/min; ASTM D790
Izod Impact, Notched	2.14 J/cm	4.00 ft-lb/in	bar; ASTM D256
	@Thickness 3.17 mm, Temperature 23.0 °C	@Thickness 0.125 in, Temperature 73.4 °F	

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	79.4 °C	175 °F	0.125 in bar Unannealed/Conditioned 48 hours at 23°C; ASTM D648
	96.1 °C	205 °F	0.125 in bar Annealed 4 hours at 80°C; ASTM D648
Vicat Softening Point	103 °C	218 °F	0.125 inch, 1 Kg; ASTM D1525
Flammability, UL94	HB	HB	
	@Thickness 1.50 mm	@Thickness 0.0591 in	

Processing Properties	Metric	English	Comments
Middle Barrel Temperature	200 - 220 °C	392 - 428 °F	

Processing Properties	Metric	English	Comments
Mold Temperature	40.0 - 60.0 °C	104 - 140 °F	Higher mold temperature provides a product with excellent surface finishing and less residual stress.
Drying Temperature	80.0 - 85.0 °C	176 - 185 °F	
Dry Time	2 - 4 hour	2 - 4 hour	
Injection Pressure	4.83 - 6.21 MPa	700 - 900 psi	

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