



DIAMOND POLYMERS, INC.

Injection Molding Grade

ABS 3500

NATURAL

Medium Impact

PROPERTIES	ASTM METHOD	UNITS ENGLISH METRIC	
PHYSICAL			
Melt Flow Rate - Procedure A Condition G (200°C/5.0 kg) Condition I (230°C/3.8kg)	D-1238	g/10 min	2.9 8.5
Specific Gravity	D-792		1.04
Mold Shrinkage	D-955	in/in cm/cm	0.004-0.006 0.004-0.006
Rockwell Hardness	D-785	R scale	108
IMPACT			
Izod Impact, notched 0.125", 23°C (73°F)	D-256	ft-lb/in J/m	3.5 187
FLEXURAL			
Flexural Modulus, tangent chs 0.05 in/mi	D-790	psi MPa	341,000 2,349
TENSILE			
Tensile Strength, chs 2 in/min @ Yield @ Break	D-638	psi (MPa) psi (MPa)	6,270 (43.2) 5,060 (34.9)
Elongation, chs 2 in/min @Yield @Break	D-638	% %	2.4 43.0
THERMAL			
Heat Deflection Temperature 0.125" bar @ 1.8 Mpa (264 psi) Unannealed/Conditioned 48 hours @ 23° C (73° F)	D-648	°F °C	171 77
Vicat Softening Point 0.125" bar/wt 1000g, 2°C/minute	D-1525	°F °C	224 107
FLAMMABILITY RATING			
Minimum Thickness 1.5mm / 0.0625in / 1/16" 2.5mm / 0.100in / 3/32" 3.0mm / 0.125in / 1/8"	UL 94		HB
U.L. File Number			E119088

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