

(+) 18816996168

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Technical Data Sheet

Diamond QR-2005-BK(RB)BLK

Acrylonitrile Butadiene Styrene

Product Description

Available with either high or low gloss.

Processing Method	Injection Molding
Attribute	Good Impact Resistance
Forms	Pellets
Appearance	Colors Available; Natural Color

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (230 °C/3.8 kg)	17	g/10 min	ASTM D1238
Density - Specific Gravity	1.06	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	45.9	MPa	ASTM D638
Flexural Strength at Yield	70.3	MPa	ASTM D790
Flexural Modulus	2490	MPa	ASTM D790
Impact			
Notched Izod Impact, (23 °C)	150	J/m	ASTM D256

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	93	°C
Nozzle Temperature	>216	°C
Processing (Melt) Temp	216 to 260	°C
Front Temperature	216 to 238	°C
Middle Temperature	204 to 210	°C
Rear Temperature	188 to 210	°C
Mold Temperature	49 to 71	°C
Drying Time, Maximum	4	hr