

Technical Data Sheet

Diamond ABS 3300GPBLK

Acrylonitrile Butadiene Styrene

Product Description

Diamond ABS 3300GPBLK is a Acrylonitrile Butadiene Styrene material and is typically used in Injection Molding applications. Features include: High Impact Resistance, and Impact Modified.

Processing Method	Injection Molding
Attribute	High Impact Resistance; Impact Modified
Forms	Pellets
Appearance	Black
Additive	Impact Modifier
Application	General Purpose

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (230 °C/3.8 kg)	5.0	g/10 min	ASTM D1238
Density - Specific Gravity	1.05	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield, (51 mm/min)	41.4	MPa	ASTM D638
Flexural Modulus, (1.3 mm/min, Tangent)	2280	MPa	ASTM D790
Impact			
Notched Izod Impact, (23 °C, 3.18 mm)	210	J/m	ASTM D256
Hardness			
Rockwell Hardness, (R-Scale)	110		ASTM D785
Thermal			
Vicat Softening Temperature	104	°C	ASTM D1525
Deflection Temperature Under Load Annealed (264 psi), (3.18 mm)	92.2	°C	ASTM D648
Deflection Temperature Under Load Unannealed (264 psi), (3.18 mm)	75.0	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	80 to 85	°C
Suggested Max Moisture	0.1	%
Front Temperature	190 to 250	°C
Middle Temperature	190 to 250	°C
Rear Temperature	190 to 250	°C
Mold Temperature	40 to 80	°C
Injection Pressure	48.3 to 75.8	MPa