

Technical Data Sheet

**Diamond ABS 3501 GF20 1002 NLNAT**

Acrylonitrile Butadiene Styrene

Product Description

Diamond ABS 3501 GF20 1002 NLNAT is a Acrylonitrile Butadiene Styrene Glass Fiber, 20% filled material. Features include: Good Impact Resistance.

Attribute	Good Impact Resistance
Forms	Pellets
Filler/Reinforcement	Glass Fiber, 20%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate			
(200 °C/5.0 kg, Procedure A)	0.80	g/10 min	ASTM D1238
(230 °C/3.8 kg, Procedure A)	2.5 to 3.0	g/10 min	ASTM D1238
Density - Specific Gravity	1.17	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield, (51 mm/min)	67.6	MPa	ASTM D638
Flexural Modulus, (1.3 mm/min, Procedure B)	4430	MPa	ASTM D790
Impact			
Notched Izod Impact, (23 °C, 3.18 mm)	64	J/m	ASTM D256
Thermal			
Vicat Softening Temperature, (Loading 1 (10 N))	113	°C	ASTM D1525
Deflection Temperature Under Load Annealed (264 psi), (3.18 mm)	102	°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
Injection Rate	Moderate-Fast	
Mold Temperature	40 to 80	°C