

Technical Data Sheet

**Diamond QR-2005IM(D)-EB25602 SF INTMD**



Acrylonitrile Butadiene Styrene

**Product Description**

Available with either high or low gloss.

<b>Processing Method</b>	Injection Molding
<b>Attribute</b>	High Impact Resistance
<b>Forms</b>	Pellets
<b>Appearance</b>	Colors Available

<b>Typical Properties</b>	<b>Nominal Value</b>	<b>Units</b>	<b>Test Method</b>
<b>Physical</b>			
Melt Flow Rate, (230 °C/3.8 kg)	5.0	g/10 min	ASTM D1238
Density - Specific Gravity	1.04	g/cm <sup>3</sup>	ASTM D792
<b>Mechanical</b>			
Tensile Strength at Yield	44.1	MPa	ASTM D638
Flexural Strength at Yield	72.4	MPa	ASTM D790
Flexural Modulus	2340	MPa	ASTM D790
<b>Impact</b>			
Notched Izod Impact			
(23 °C)	370	J/m	ASTM D256
(-40 °C)	64	J/m	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (264 psi)	85	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	93.3	°C	ASTM D648

<b>Injection Parameters</b>	<b>Nominal Value</b>	<b>Units</b>
Drying Time	2.0 to 4.0	hr
Drying Temperature	93	°C
Nozzle Temperature	216 to 260	°C
Processing (Melt) Temp	216 to 260	°C
Front Temperature	216 to 238	°C
Middle Temperature	204 to 227	°C
Rear Temperature	188 to 210	°C
Mold Temperature	49 to 71	°C
Drying Time, Maximum	4	hr