

Technical Data Sheet

Diamond QR-2005IM(D)-EB25602BLK



Acrylonitrile Butadiene Styrene

Product Description

Available with either high or low gloss.

| | |
|--------------------------|------------------------|
| Processing Method | Injection Molding |
| Attribute | High Impact Resistance |
| Forms | Pellets |
| Appearance | Colors Available |

| 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 | 1.04 | g/cm ³ | ASTM D792 |
| Mechanical | | | |
| Tensile Strength at Yield | 44.1 | MPa | ASTM D638 |
| Flexural Strength at Yield | 72.4 | MPa | ASTM D790 |
| Flexural Modulus | 2340 | MPa | ASTM D790 |
| Impact | | | |
| Notched Izod Impact | | | |
| (23 °C) | 370 | J/m | ASTM D256 |
| (-40 °C) | 64 | J/m | ASTM D256 |
| Thermal | | | |
| Deflection Temperature Under Load Unannealed (264 psi) | 85 | °C | ASTM D648 |
| Deflection Temperature Under Load Unannealed (66 psi) | 93.3 | °C | ASTM D648 |

| Injection Parameters | Nominal Value | Units |
|------------------------|---------------|-------|
| 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 |