



Diamond ABS 3500LG CHARCOAL GREY 2A920

LyondellBasell Industries - Acrylonitrile Butadiene Styrene

General Information

Product Description

Diamond ABS 3500LG CHARCOAL GREY 2A920 is a Acrylonitrile Butadiene Styrene material and is typically used in Injection Molding applications. Features include: Low Gloss, Medium Flow, and Medium Impact Resistance.

General

Features	• Low Gloss	• Medium Flow	• Medium Impact Resistance
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.04		ASTM D792
Melt Mass-Flow Rate (MFR) ²			ASTM D1238
200°C/5.0 kg	2.3	g/10 min	
230°C/3.8 kg	6.0	g/10 min	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ³ (Yield)	6000	psi	ASTM D638
Flexural Modulus - Tangent ⁴	300000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	4.7	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	104		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.125 in, Injection Molded	170	°F	
Vicat Softening Temperature	219	°F	ASTM D1525 ⁵

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176 to 185	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	392 to 428	°F
Middle Temperature	392 to 428	°F
Front Temperature	392 to 428	°F
Mold Temperature	104 to 140	°F
Injection Rate	Slow-Moderate	