

Technical Data Sheet

Diamond ABS 7501 2391GRN



Acrylonitrile Butadiene Styrene

Product Description

Diamond ABS 7501 2391GRN is a Acrylonitrile Butadiene Styrene material and is typically used in Injection Molding applications. Features include: Ultra High Impact Resistance.

Processing Method	Injection Molding
Attribute	Ultra High Impact Resistance
Forms	Pellets

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (230 °C/3.8 kg, Procedure A)	3.6	g/10 min	ASTM D1238
Density - Specific Gravity	1.04	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield, (51 mm/min)	42.7	MPa	ASTM D638
Flexural Modulus, (1.3 mm/min, Tangent)	1970	MPa	ASTM D790
Impact			
Notched Izod Impact, (23 °C, 3.18 mm)	400	J/m	ASTM D256
Hardness			
Rockwell Hardness, (R-Scale)	101		ASTM D785
Thermal			
Vicat Softening Temperature, (Loading 1 (10 N))	103	°C	ASTM D1525
Deflection Temperature Under Load Annealed (264 psi), (3.18 mm)	92.8	°C	ASTM D648
Deflection Temperature Under Load Unannealed (264 psi), (3.18 mm)	77.2	°C	ASTM D648
UL Information			
Flame Rating, (1.5 mm)	HB		UL 94
UL File Number	E150937		

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