



DIAMOND POLYMERS, INC.

Injection Molding Grade

**ABS 3500**  
**Natural 1003**

High Flow, Medium Impact  
Low Gloss

PROPERTIES	ASTM METHOD	UNITS ENGLISH METRIC	
<b>PHYSICAL</b>			
Melt Flow Rate - Procedure A Condition G (200° C/5.0 kg) Condition I (230° C/3.8 kg)	D-1238	g/10 min g/10 min	-- 12.0
Specific Gravity	D-792		1.04
Mold Shrinkage	D-955	in/in cm/cm	0.004 - 0.007 0.004 - 0.007
Rockwell Hardness	D-785	R scale	104
<b>IMPACT</b>			
Izod Impact, notched 0.125", 23° C (73° F)	D-256	ft-lb/in J/m	2.5 133
<b>FLEXURAL</b>			
Flexural Modulus, tangent, chs 0.05 in/min	D-790	psi MPa	300,000 2,067
<b>TENSILE</b>			
Tensile Yield Strength, chs 2 in/min	D-638	psi MPa	6,000 41.3
<b>THERMAL</b>			
Heat Deflection Temperature 0.125" bar @ 1.8 Mpa (264 psi) Unannealed/Conditioned 48 hours @ 23° C (73° F)	D-648	°F °C	165 74
Vicat Softening Point, 0.125", 1Kg	D-1525	°F °C	215 102
<b>FLAMMABILITY RATING</b>			
Minimum Thickness 1.5mm / 0.0625in / 1/16" 2.5mm / 0.100in / 3/32" 3.0mm / 0.125in / 1/8"	UL 94		HB

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