

Technical Data Sheet

**Diamond Abs 3501 GF-10**

Acrylonitrile Butadiene Styrene
LyondellBasell Industries
Engineering Plastics

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Features	• Good Impact Resistance
Forms	• Pellets

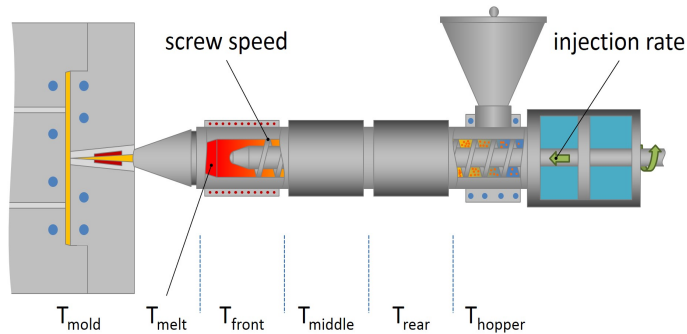
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.11	1.11 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹			ASTM D1238
200°C/5.0 kg	1.1 g/10 min	1.1 g/10 min	
230°C/3.8 kg	3.5 g/10 min	3.5 g/10 min	
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength ² (Yield)	8400 psi	57.9 MPa	ASTM D638
Flexural Modulus - Tangent ³	467000 psi	3220 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.125 in (3.18 mm)	1.7 ft·lb/in	91 J/m	
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-Scale)	113	113	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.125 in (3.18 mm)	201 °F	93.9 °C	
264 psi (1.8 MPa), Annealed, 0.125 in (3.18 mm)	212 °F	100 °C	
Vicat Softening Temperature	232 °F	111 °C	ASTM D1525 ⁴

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 to 185 °F	80 to 85 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.10 %	0.10 %
Rear Temperature	374 to 482 °F	190 to 250 °C
Middle Temperature	374 to 482 °F	190 to 250 °C
Front Temperature	374 to 482 °F	190 to 250 °C
Mold Temperature	104 to 176 °F	40 to 80 °C
Injection Rate	Moderate-Fast	Moderate-Fast

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Notes

¹ Procedure A

² 2.0 in/min (51 mm/min)

³ 0.050 in/min (1.3 mm/min)

⁴ Loading 1 (10 N)

Notes

These are typical property values not to be construed as specification limits.

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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