

Diamond ABS VP-33 1002 Natural

Acrylonitrile Butadiene Styrene

Network Polymers, Inc.

Message:

Diamond ABS VP-33 is a flame retardant ABS (non-PBBE additives). Excellent moldability and toughness. UL94 V-0 rating @ 1/16" (1.5mm). Diamond ABS VP-33 is available in custom colors.

General Information			
UL YellowCard	E51193-101898811		
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Moldability		
	Good Toughness		
Agency Ratings	EU 2002/96/EC (WEEE)		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (230°C/3.8 kg)	8.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (Injection Molded)	0.50 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	98		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, Injection Molded ²	41.4	MPa	
Break, 23°C, 3.18 mm, Injection Molded ³	33.8	MPa	
Tensile Elongation ⁴			ASTM D638
Yield, 23°C, 3.18 mm, Injection Molded	2.3	%	
Break, 23°C, 3.18 mm, Injection Molded	29	%	
Flexural Modulus - Tangent ⁵ (Injection Molded)	2300	MPa	ASTM D790A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	140	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.18 mm, Injection Molded	71.1	°C	ASTM D648A

1.8 MPa, Annealed, 3.18 mm	92.2	°C	ASTM D648
Vicat Softening Temperature	93.3	°C	ASTM D1525 ⁶
RTI Elec (1.50 mm)	60.0	°C	UL 746
RTI Imp (1.50 mm)	60.0	°C	UL 746
RTI Str (1.50 mm)	60.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm, ALL, All Colors)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 87.8	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.10	%	
Suggested Shot Size	50 to 70	%	
Rear Temperature	171 to 182	°C	
Middle Temperature	193 to 204	°C	
Front Temperature	199 to 216	°C	
Nozzle Temperature	199 to 221	°C	
Processing (Melt) Temp	199 to 221	°C	
Mold Temperature	48.9 to 71.1	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	30 to 60	rpm	
Vent Depth	0.038 to 0.051	mm	
NOTE			
1.	Procedure A		
2.	Type I, 51 mm/min		
3.	Type I		
4.	Type I		
5.	Method I (3 point load), Type I, 1.3 mm/min		
6.	Loading 1 (10 N)		

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