

DENKA ABS GR-1000

Acrylonitrile Butadiene Styrene

Denka Company Limited

Message:

DENKA ABS GR-1000 is an Acrylonitrile Butadiene Styrene (ABS) product. It is available in Asia Pacific, Europe, or North America.

Characteristics include:

Flame Rated

Impact Resistant

General Information			
UL YellowCard	E49895-241438		
Features	Good Impact Resistance		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.05	g/cm ³	ASTM D792
23°C	1.05	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	18	g/10 min	ISO 1133
Molding Shrinkage (2.00 mm)	0.40 to 0.60	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	120		ASTM D785
R-Scale	114		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	50.0	MPa	ASTM D638
--	2750	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	54.0	MPa	
Break	37.0	MPa	
Nominal Tensile Strain at Break	27	%	ISO 527-2/50
Flexural Modulus			
-- ²	2650	MPa	ASTM D790
-- ³	2650	MPa	ISO 178
Flexural Strength			
-- ⁴	82.0	MPa	ASTM D790
-- ⁵	85.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	12	kJ/m ²	ISO 179
Notched Izod Impact	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			
1.8 MPa, Unannealed ⁶	89.0	°C	ASTM D648
1.8 MPa, Unannealed	81.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	103	°C	ASTM D1525 ⁷
--	104	°C	ISO 306/B
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity ⁸	> 1.0E+16	ohms	JIS K6911
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	180 to 200	°C	
Middle Temperature	190 to 220	°C	
Front Temperature	200 to 240	°C	
Nozzle Temperature	200 to 235	°C	
Mold Temperature	40.0 to 60.0	°C	
Back Pressure	0.490 to 0.981	MPa	
Screw Speed	80 to 120	rpm	
NOTE			
1.	5.0 mm/min		
2.	15 mm/min		
3.	2.0 mm/min		
4.	15 mm/min		
5.	2.0 mm/min		
6.	Edgewise		
7.	Loading 2 (50 N)		
8.	23°C, 50% RH		

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