

MALECCA K-100

Acrylonitrile Butadiene Styrene

Denka Company Limited

Message:

MALECCA K-100 is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in Asia Pacific, Europe, or North America. Primary characteristic: flame rated.

General Information			
UL YellowCard	E49895-241473		
UL File Number	E49895		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.05	g/cm ³	ASTM D792
23°C	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	8.0	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	114		ASTM D785
R-Scale	113		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	42.0	MPa	ASTM D638
--	2500	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	48.0	MPa	
Break	38.0	MPa	
Nominal Tensile Strain at Break	28	%	ISO 527-2/50
Flexural Modulus			
-- ²	2350	MPa	ASTM D790
-- ³	2450	MPa	ISO 178
Flexural Strength			
-- ⁴	74.0	MPa	ASTM D790
-- ⁵	76.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	20	kJ/m ²	ISO 179
Notched Izod Impact	200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

1.8 MPa, Unannealed ⁶	103	°C	ASTM D648
1.8 MPa, Unannealed	93.0	°C	ISO 75-2/Af
Vicat Softening Temperature	113	°C	ISO 306/B, ASTM D1525 ⁷
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0	°C	
Drying Time	3.0 to 4.0	hr	
Rear Temperature	200 to 220	°C	
Middle Temperature	210 to 240	°C	
Front Temperature	220 to 250	°C	
Nozzle Temperature	220 to 245	°C	
Mold Temperature	50.0 to 80.0	°C	
Back Pressure	0.490 to 0.981	MPa	
Screw Speed	50 to 80	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)		

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