

MALECCA K-300

Acrylonitrile Butadiene Styrene

Denka Company Limited

Message:

MALECCA is a high heat resistant ABS resin which is based on styrene-N-phenylmaleimide copolymer. MALECCA was developed by Denka using their advanced polymerization technologies. This high heat ABS is much more highly improved in the areas of heat stability, processing characteristics and impact strength over traditional alpha-methylstyrene-based resins and is very easy to use.

General Information			
UL YellowCard	E49895-241476		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.06	g/cm ³	ASTM D792
23°C	1.08	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	4.0	g/10 min	ISO 1133
Molding Shrinkage (2.00 mm)	0.50 to 0.80	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	114		ASTM D785
R-Scale	116		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	41.0	MPa	ASTM D638
--	2450	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	48.0	MPa	
Break	40.0	MPa	
Nominal Tensile Strain at Break	21	%	ISO 527-2/50
Flexural Modulus			
-- ²	2250	MPa	ASTM D790
-- ³	2450	MPa	ISO 178
Flexural Strength			
-- ⁴	75.0	MPa	ASTM D790
-- ⁵	79.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	16	kJ/m ²	ISO 179
Notched Izod Impact	180	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

1.8 MPa, Unannealed ⁶	110	°C	ASTM D648
1.8 MPa, Unannealed	100	°C	ISO 75-2/Af
Vicat Softening Temperature	120	°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 to 100	°C	
Drying Time	3.0 to 4.0	hr	
Rear Temperature	210 to 230	°C	
Middle Temperature	220 to 250	°C	
Front Temperature	230 to 260	°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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