

DENKA Transparent Polymer TE-20S

Acrylonitrile Butadiene Styrene

Denka Company Limited

Message:

DENKA Transparent Polymer TE-20S is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in Asia Pacific, Europe, or North America.

Characteristics include:

Flame Rated

Rigid

General Information			
UL YellowCard	E49895-101153464	E49895-520289	
Features	High Rigidity		
UL File Number	E49895		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.11	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)			ISO 1133
200°C/5.0 kg	2.0	g/10 min	
220°C/10.0 kg	28	g/10 min	
Molding Shrinkage (2.00 mm)	0.50	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	54		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	48.0	MPa	ISO 527-2/50
Nominal Tensile Strain at Break	34	%	ISO 527-2/50
Flexural Modulus ¹	2300	MPa	ISO 178
Flexural Stress ²	74.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	10	kJ/m²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	73.0	°C	ISO 75-2/Af
Vicat Softening Temperature	93.0	°C	ISO 306/B
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Optical	Nominal Value	Unit	Test Method
Transmittance (2000 µm)	91.0	%	ISO 13468-1
Haze (2000 µm)	1.3	%	ISO 14782
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	

Drying Time	2.0 to 3.0	hr
Rear Temperature	200 to 240	°C
Middle Temperature	200 to 240	°C
Front Temperature	200 to 240	°C
Nozzle Temperature	230 to 240	°C
Mold Temperature	40.0 to 70.0	°C

NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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