

DENKA Polymer Alloy HS-G193

Polycarbonate + ABS
Denka Company Limited

Message:

DENKA Polymer Alloy HS-G193 is a Polycarbonate + ABS (PC+ABS) product. It is available in Asia Pacific, Europe, or North America. Primary characteristic: flame rated.

General Information			
UL YellowCard	E49895-241462		
Features	Good Flow		
UL File Number	E49895		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.13	g/cm ³	ASTM D792
23°C	1.12	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	10	g/10 min	ISO 1133
Molding Shrinkage (2.00 mm)	0.50 to 0.70	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	120		ASTM D785
R-Scale	121		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	56.0	MPa	ASTM D638
--	2460	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	62.0	MPa	
Break	48.0	MPa	
Nominal Tensile Strain at Break	60	%	ISO 527-2/50
Flexural Modulus			
-- ²	2550	MPa	ASTM D790
-- ³	2550	MPa	ISO 178
Flexural Strength			
-- ⁴	88.0	MPa	ASTM D790
-- ⁵	93.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	75	kJ/m ²	ISO 179
Notched Izod Impact	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

1.8 MPa, Unannealed ⁶	105	°C	ASTM D648
1.8 MPa, Unannealed	99.0	°C	ISO 75-2/Af
Vicat Softening Temperature	115	°C	ISO 306/B, ASTM D1525 ⁷
Flammability	Nominal Value	Test Method	
Flame Rating	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	220 to 240	°C	
Middle Temperature	230 to 250	°C	
Front Temperature	240 to 260	°C	
Nozzle Temperature	240 to 260	°C	
Mold Temperature	60.0 to 90.0	°C	
Back Pressure	0.490 to 1.47	MPa	
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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