

Denka

DENKA's Polymer Alloy Physical properties

Pproperty	Test Methods	Conditions	Unit	HS-G193	HS-K190
				ABS/PC Good Flow	ABS/PC Super High Impact

◆ISO Method

Melt Mass Flow Rate	ISO 1133	220deg.C 98N	g/10min	10	7
Tensile Modulus	ISO 527-1, -2	1mm/min	MPa	2,460	2,330
Tensile stress at yield		50mm/min	MPa	62	58
Tensile stress at break			MPa	48	47
Flexural Modulus	ISO 178	2mm/min	MPa	2,550	2,450
Flexural Strength			MPa	93	90
Charpy Impact Strength	ISO 179	Notched	kJ/m ²	75	110
Temp of deflection under load	ISO 75-1, -2	1.8MPa Flatwise	deg.C	99	99
Vicat Softening Temp	ISO 306	50N	deg.C	115	115
Rockwell Hardness	ISO 2039-2	R-scale	-	121	119
Density	ISO 1183	23 deg.C	kg/m ³	1,120	1,120

◆ASTM Method

Tensile Modulus	ASTM D-638	5mm/min	MPa	56	51
Flexural Modulus	ASTM D-790	15mm/min	MPa	2,550	2,260
Flexural Strength			MPa	88	80
Izod Impact Strength	ASTM D-256	Notched	J/m	637	1,177
Heat Deflection Temperature	ASTM D-648	1.8MPa Edgewise	deg.C	105	107
Vicat Softing Temperature	ASTM D-1525	50N	deg.C	115	118
Rockwell Hardness	ASTM D-785	R-scale	-	120	118
Density	ASTM D-792	23 deg.C	-	1.13	1.12

◆Other properties

Flammability	UL94 (UL File No.E49895)			HB	HB
Molding Shrinkage	DENKA Method	2mmt	%	0.5~0.7	0.5~0.7

* The above values are typical and not guaranteed.

Last update : 31-May-2016

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◆ Processing Condition

Pre-drying Condition

Temperature [deg.C]	Time [hr]
110	3~5

Molding Condition

Cylinder temperature setting [deg.C]				Grade
C1	C2	C3	Nozzle	
220	230	240	240	HS-G193, HS-K190
∧	∧	∧	∧	
240	250	260	260	

Mold temperature : 60~90 [deg.C] (actual temperature of mold surface)

Back pressure : 5~15 [kg/cm²·G]