

MALECCA K-400

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	E49895-241477		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.08	g/cm ³	ASTM D792
23°C	1.08	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ISO 1133
220°C/10.0 kg	2.0	g/10 min	
265°C/10.0 kg	22	g/10 min	
Molding Shrinkage (2.00 mm)	0.50 to 0.80	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	116		ASTM D785
R-Scale	117		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	46.0	MPa	ASTM D638
--	2650	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	51.0	MPa	
Break	45.0	MPa	
Nominal Tensile Strain at Break	27	%	ISO 527-2/50
Flexural Modulus			
-- ²	2750	MPa	ASTM D790
-- ³	2650	MPa	ISO 178
Flexural Strength			
-- ⁴	83.0	MPa	ASTM D790
-- ⁵	86.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	13	kJ/m ²	ISO 179
Notched Izod Impact	140	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			
1.8 MPa, Unannealed ⁶	115	°C	ASTM D648
1.8 MPa, Unannealed	104	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	126	°C	ASTM D1525 ⁷
--	125	°C	ISO 306/B
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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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