

DENKA ABS GR-3500

Acrylonitrile Butadiene Styrene

Denka Company Limited

Message:

DENKA ABS GR-3500 is an Acrylonitrile Butadiene Styrene (ABS) product. It is available in Asia Pacific, Europe, or North America.

Characteristics include:

Flame Rated

Impact Resistant

General Information			
UL YellowCard	E49895-241444		
Features	Good Flow		
	High Impact Resistance		

Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.03	g/cm ³	ASTM D792
23°C	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	14	g/10 min	ISO 1133
Molding Shrinkage (2.00 mm)	0.40 to 0.60	%	Internal Method

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	109		ASTM D785
R-Scale	104		ISO 2039-2

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	38.0	MPa	ASTM D638
--	2200	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	41.0	MPa	
Break	32.0	MPa	
Nominal Tensile Strain at Break	33	%	ISO 527-2/50
Flexural Modulus			
-- ²	2150	MPa	ASTM D790
-- ³	2050	MPa	ISO 178
Flexural Strength			
-- ⁴	63.0	MPa	ASTM D790
-- ⁵	65.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	30	kJ/m ²	ISO 179

Notched Izod Impact	310	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed ⁶	85.0	°C	ASTM D648
1.8 MPa, Unannealed	76.0	°C	ISO 75-2/Af
Vicat Softening Temperature	95.0	°C	ISO 306/B, ASTM D1525 ⁷
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity ⁸	> 1.0E+16	ohms	JIS K6911
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 85.0	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	180 to 200	°C	
Middle Temperature	200 to 230	°C	
Front Temperature	210 to 260	°C	
Nozzle Temperature	210 to 255	°C	
Mold Temperature	40.0 to 60.0	°C	
Back Pressure	0.490 to 0.981	MPa	
Screw Speed	80 to 120	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)		
8.	23°C, 50% RH		

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