

DENKA Transparent Polymer CL-430

Acrylonitrile Butadiene Styrene

Denka Company Limited

Message:

DENKA Transparent Polymer CL-430 is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in Asia Pacific, Europe, or North America. Primary characteristic: flame rated.

General Information			
UL YellowCard	E49895-241625		
UL File Number	E49895		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.08	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ISO 1133
200°C/5.0 kg	2.7	g/10 min	
220°C/10.0 kg	34	g/10 min	
Molding Shrinkage (2.00 mm)	0.40	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	31		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			ISO 527-2/50
Yield	42.0	MPa	
Break	31.0	MPa	
Nominal Tensile Strain at Break	40	%	ISO 527-2/50
Flexural Modulus ¹	2000	MPa	ISO 178
Flexural Stress ²	62.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	14	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	64.0	°C	ISO 75-2/Af
Vicat Softening Temperature	80.0	°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)	2.0	%	ISO 14782
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 80.0	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	210 to 220	°C	

Middle Temperature	210 to 220	°C
Front Temperature	210 to 220	°C
Nozzle Temperature	220 to 230	°C
Mold Temperature	40.0 to 70.0	°C

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

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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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