

MALECCA K-700

Acrylonitrile Butadiene Styrene

Denka Company Limited

Message:

MALECCA K-700 is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in Asia Pacific, Europe, or North America.

General Information			
UL File Number	E49895		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.09	g/cm ³	ASTM D792
23°C	1.09	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/10.0 kg)	6.0	g/10 min	ISO 1133
Molding Shrinkage (2.00 mm)	0.80 to 1.0	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	120		ASTM D785
R-Scale	112		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	39.0	MPa	ASTM D638
--	1900	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	37.0	MPa	
Break	37.0	MPa	
Nominal Tensile Strain at Break	11	%	ISO 527-2/50
Flexural Modulus			
-- ²	1850	MPa	ASTM D790
-- ³	1900	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	7.0	kJ/m ²	ISO 179
Notched Izod Impact	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed ⁶	138	°C	ASTM D648

1.8 MPa, Unannealed	126	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	151	°C	ASTM D1525 ⁷
--	150	°C	ISO 306/B
Injection	Nominal Value	Unit	
Drying Temperature	100 to 110	°C	
Drying Time	3.0 to 4.0	hr	
Rear Temperature	220 to 240	°C	
Middle Temperature	230 to 260	°C	
Front Temperature	240 to 270	°C	
Nozzle Temperature	240 to 265	°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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