

**DENKA QF**

ABS

Denka Company Limited

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	44	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2400	MPa	ISO 527
Yield stress	45	MPa	ISO 527
Stress at break	34	MPa	ISO 527
Flexural modulus, 23°C	2350	MPa	ISO 178
Flexural strength	72	MPa	ISO 178
Charpy notched impact strength, +23°C	19	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	R 110	-	ISO 2039-2
<b>ASTM Data</b>			
Flexural Modulus	2400	MPa	ASTM D 790
Flexural Strength	70	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	196	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	75	°C	ISO 75-1/-2
Vicat softening temperature, B	97	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Yellow Card available	yes	-	-
<b>ASTM Data</b>			
DTUL @ 264 psi	86	°C	ASTM D 648
Vicat Temperature	99	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1040	kg/m <sup>3</sup>	ISO 1183
Density	1040	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 85	°C	-
Pre-drying - Time	2 - 3	h	-
Mold temperature	40 - 60	°C	-
Zone 1	170 - 190	°C	-
Zone 2	180 - 215	°C	-
Zone 3	190 - 230	°C	-
Nozzle temperature	190 - 225	°C	-
Screw speed	80 - 120	rpm	-
Back pressure	0.5 - 1	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific