

**DENKA HS-G193**

(ABS+PC)

Denka Company Limited

| Processing/Physical Characteristics | Value | Unit    | Test Standard   |
|-------------------------------------|-------|---------|-----------------|
| <b>ISO Data</b>                     |       |         |                 |
| Melt flow index, MFI                | 10    | g/10min | ISO 1133        |
| Temperature                         | 220   | °C      | -               |
| Load                                | 10    | kg      | -               |
| Molding shrinkage, parallel         | 0.6   | %       | ISO 294-4, 2577 |

| Mechanical properties                 | Value | Unit              | Test Standard |
|---------------------------------------|-------|-------------------|---------------|
| <b>ISO Data</b>                       |       |                   |               |
| Tensile Modulus                       | 2460  | MPa               | ISO 527       |
| Yield stress                          | 62    | MPa               | ISO 527       |
| Stress at break                       | 48    | MPa               | ISO 527       |
| Flexural modulus, 23°C                | 2550  | MPa               | ISO 178       |
| Flexural strength                     | 93    | MPa               | ISO 178       |
| Charpy notched impact strength, +23°C | 75    | kJ/m <sup>2</sup> | ISO 179/1eA   |
| Rockwell hardness                     | R 121 | -                 | ISO 2039-2    |
| <b>ASTM Data</b>                      |       |                   |               |
| Flexural Modulus                      | 2550  | MPa               | ASTM D 790    |
| Flexural Strength                     | 88    | MPa               | ASTM D 790    |
| Rockwell Hardness                     | R 120 | -                 | ASTM D 785    |
| Izod Impact notched, 1/8 in           | 637   | J/m               | ASTM D 256    |

| Thermal properties                       | Value | Unit  | Test Standard   |
|--|-------|-------|-----------------|
| <b>ISO Data</b>                          |       |       |                 |
| Temp. of deflection under load, 1.80 MPa | 99    | °C    | ISO 75-1/-2     |
| Vicat softening temperature, B           | 115   | °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                           | 105   | °C    | ASTM D 648      |
| Vicat Temperature                        | 115   | °C    | ASTM D 1525     |

| Other properties | Value | Unit              | Test Standard |
|------------------|-------|-------------------|---------------|
| Density          | 1120  | kg/m <sup>3</sup> | ISO 1183      |
| Density          | 1130  | kg/m <sup>3</sup> | ASTM D 792    |

| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature                    | 110       | °C   | -             |
| Pre-drying - Time                           | 3 - 5     | h    | -             |
| Mold temperature                            | 60 - 90   | °C   | -             |
| Zone 1                                      | 220 - 240 | °C   | -             |
| Zone 2                                      | 230 - 250 | °C   | -             |
| Zone 3                                      | 240 - 260 | °C   | -             |
| Nozzle temperature                          | 240 - 260 | °C   | -             |
| Back pressure                               | 0.5 - 1.5 | MPa  | -             |

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific