

**DENKA APG-3000**

ABS

Denka Company Limited

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	23	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	2200	MPa	ISO 527
Yield stress	40	MPa	ISO 527
Stress at break	30	MPa	ISO 527
Flexural modulus, 23°C	1930	MPa	ISO 178
Flexural strength	60	MPa	ISO 178
Charpy notched impact strength, +23°C	33	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	R 95	-	ISO 2039-2
<b>ASTM Data</b>			
Flexural Modulus	1900	MPa	ASTM D 790
Flexural Strength	57	MPa	ASTM D 790
Rockwell Hardness	R 95	-	ASTM D 785
Izod Impact notched, 1/8 in	342	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	91	°C	ISO 306
<b>ASTM Data</b>			
DTUL @ 264 psi	84	°C	ASTM D 648
Vicat Temperature	90	°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	180 - 200	°C	-
Zone 2	200 - 230	°C	-
Zone 3	210 - 260	°C	-
Nozzle temperature	210 - 255	°C	-
Screw speed	80 - 120	rpm	-
Back pressure	0.5 - 1	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Special Characteristics**

Anti-static