

DENKA CL-430

ABS

Denka Company Limited

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	2.7	g/10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Yield stress	42	MPa	ISO 527
Stress at break	31	MPa	ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Flexural strength	62	MPa	ISO 178
Charpy notched impact strength, +23°C	14	kJ/m ²	ISO 179/1eA
Rockwell hardness	M 31	-	ISO 2039-2
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	64	°C	ISO 75-1/-2
Vicat softening temperature, B	80	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Yellow Card available	yes	-	-
Optical properties			
ISO Data			
Haze	2	-	ISO 14782
Other properties			
Density	1080	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Pre-drying - Temperature	70 - 80	°C	-
Pre-drying - Time	2 - 3	h	-
Mold temperature	40 - 70	°C	-
Zone 1	210 - 220	°C	-
Nozzle temperature	220 - 230	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Special Characteristics

Transparent