

DENKA GR-3000

ABS

Denka Company Limited

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	8	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2200	MPa	ISO 527
Yield stress	42	MPa	ISO 527
Stress at break	32	MPa	ISO 527
Flexural modulus, 23°C	1950	MPa	ISO 178
Flexural strength	65	MPa	ISO 178
Charpy notched impact strength, +23°C	30	kJ/m ²	ISO 179/1eA
Rockwell hardness	R 103	-	ISO 2039-2
ASTM Data			
Flexural Modulus	2000	MPa	ASTM D 790
Flexural Strength	64	MPa	ASTM D 790
Rockwell Hardness	R 109	-	ASTM D 785
Izod Impact notched, 1/8 in	304	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	77	°C	ISO 75-1/-2
Vicat softening temperature, B	100	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Yellow Card available	yes	-	-
ASTM Data			
DTUL @ 264 psi	85	°C	ASTM D 648
Vicat Temperature	98	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1030	kg/m ³	ISO 1183
Density	1030	kg/m ³	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

High impact or impact modified