

**DENKA GT-R-61A**

ABS

Denka Company Limited

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	<b>74</b>	g/10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
Molding shrinkage, parallel	<b>0.5</b>	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	<b>2700</b>	MPa	ISO 527
Yield stress	<b>47</b>	MPa	ISO 527
Stress at break	<b>35</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>2600</b>	MPa	ISO 178
Flexural strength	<b>78</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>11</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	<b>R 113</b>	-	ISO 2039-2
<b>ASTM Data</b>			
Flexural Modulus	<b>2500</b>	MPa	ASTM D 790
Flexural Strength	<b>76</b>	MPa	ASTM D 790
Rockwell Hardness	<b>R 113</b>	-	ASTM D 785
Izod Impact notched, 1/8 in	<b>108</b>	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>77</b>	°C	ISO 75-1/-2
Vicat softening temperature, B	<b>96</b>	°C	ISO 306
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Yellow Card available	<b>yes</b>	-	-
<b>ASTM Data</b>			
DTUL @ 264 psi	<b>86</b>	°C	ASTM D 648
Vicat Temperature	<b>98</b>	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	<b>1050</b>	kg/m <sup>3</sup>	ISO 1183
Density	<b>1040</b>	kg/m <sup>3</sup>	ASTM D 792

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

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific