

**DENKA TE-20S**

ABS

Denka Company Limited

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	<b>28</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

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Yield stress	<b>48</b>	MPa	ISO 527
Flexural modulus, 23°C	<b>2300</b>	MPa	ISO 178
Flexural strength	<b>74</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>10</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	<b>M 54</b>	-	ISO 2039-2

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>73</b>	°C	ISO 75-1/-2
Vicat softening temperature, B	<b>93</b>	°C	ISO 306
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Yellow Card available	<b>yes</b>	-	-

<b>Optical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Haze	<b>1.3</b>	-	ISO 14782
Luminous transmittance	<b>91</b>	%	ISO 13468-1, -2

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1110</b>	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>80</b>	°C	-
Pre-drying - Time	<b>2 - 3</b>	h	-
Mold temperature	<b>40 - 70</b>	°C	-
Zone 1	<b>200 - 240</b>	°C	-
Nozzle temperature	<b>230 - 240</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Special Characteristics**

Transparent