MALECCA K-400

ABS — Denka Company Limited

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**2**	g/10min	ISO 1133
Temperature	**220**	°C	-
Load	**10**	kg	-
Molding shrinkage, parallel	**0.7**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2650**	MPa	ISO 527
Yield stress	**51**	MPa	ISO 527
Stress at break	**45**	MPa	ISO 527
Flexural modulus, 23°C	**2650**	MPa	ISO 178
Flexural strength	**86**	MPa	ISO 178
Charpy notched impact strength, +23°C	**13**	kJ/m²	ISO 179/1eA
Rockwell hardness	**R 117**	-	ISO 2039-2
ASTM Data			
Flexural Modulus	**2750**	MPa	ASTM D 790
Flexural Strength	**83**	MPa	ASTM D 790
Rockwell Hardness	**R 116**	-	ASTM D 785
Izod Impact notched, 1/8 in	**142**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**104**	°C	ISO 75-1/-2
Vicat softening temperature, B	**125**	°C	ISO 306
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10
Yellow Card available	**yes**	-	-
ASTM Data			
DTUL @ 264 psi	**115**	°C	ASTM D 648
Vicat Temperature	**126**	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	**1080**	kg/m³	ISO 1183
Density	**1080**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**90 - 100**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Mold temperature	**50 - 80**	°C	-
Zone 1	**210 - 230**	°C	-
Zone 2	**220 - 250**	°C	-
Zone 3	**230 - 260**	°C	-
Nozzle temperature	**230 - 250**	°C	-
Screw speed	**50 - 80**	rpm	-
Back pressure	**0.5 - 1**	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Special Characteristics

Heat stabilized or stable to heat