

MALECCA K-510

ABS

Denka Company Limited

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	20	g/10min	ISO 1133
Temperature	265	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.8	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2200	MPa	ISO 527
Yield stress	41	MPa	ISO 527
Stress at break	38	MPa	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	70	MPa	ISO 178
Charpy notched impact strength, +23°C	12	kJ/m ²	ISO 179/1eA
Rockwell hardness	R 112	-	ISO 2039-2
ASTM Data			
Flexural Modulus	2050	MPa	ASTM D 790
Flexural Strength	71	MPa	ASTM D 790
Rockwell Hardness	R 114	-	ASTM D 785
Izod Impact notched, 1/8 in	157	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	107	°C	ISO 75-1/-2
Vicat softening temperature, B	131	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Yellow Card available	yes	-	-
ASTM Data			
DTUL @ 264 psi	118	°C	ASTM D 648
Vicat Temperature	129	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1080	kg/m ³	ISO 1183
Density	1080	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	3 - 4	h	-
Mold temperature	50 - 80	°C	-
Zone 1	220 - 240	°C	-
Zone 2	230 - 260	°C	-
Zone 3	240 - 270	°C	-
Nozzle temperature	240 - 265	°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