--- MBS Resin ---

DENKA TH Polymer

DENKA
DENKI KAGAKU KOGYO KABUSHIKI KAISHA

Physical properties

Ptroperty	Test Methods	Conditions	Unit	*TH-11*	*TH-21*	*TH-23*
				High Flow	General Purpose	High Impact
Melt Mass Flow Rate	ISO 1133	200deg.C 49N	g/10min	**5.2**	**3.1**	**3.9**
		220deg.C 98N		**76**	**47**	**59**
Tensile stress at yield	ISO 527-1, -2	5mm/min	MPa	**47**	**51**	**44**
Nominal strain at break			%	**36**	**36**	**34**
Flexural Modulus	ISO 178	2mm/min	MPa	**2,250**	**2,400**	**2,100**
Flexural Strength			MPa	**68**	**72**	**65**
Charpy Impact Strength	ISO 179	Notched	kJ/m^2	**9**	**11**	**12**
Deflection temperature under load	ISO 75-1, -2	1.8MPa Flatwise	deg.C	**64**	**65**	**63**
Vicat Softing Temperture	ISO 306	50N	deg.C	**84**	**86**	**84**
Rockwell Hardness	ISO 2039-2	M-scale	-	**34**	**39**	**29**
Density	ISO 1183	23 deg.C	kg/m^3	**1,086**	**1,085**	**1,082**
Light Transmission	ISO 13468-1	2mmt	%	**91**	**91**	**91**
Haze	ISO 14782	2mmt	%	**2.6**	**2.4**	**2.7**
Molding Shrinkage	DENKA Method	2mmt	%	**0.4**	**0.4**	**0.4**
Flammability	UL94 (UL File No.E49895)			**HB**	**HB**	**HB**

＊ The above values are typical and not guaranteed.

Injection Molding Condision

	Unit	TH-11	TH-21	TH-23
Pre-drying	Temp. [deg.C]	70 ～ 80		
	Time [hr]	2 ～ 3		
Cylinder Temperature	[deg.C]	180 ～ 220	200 ～ 240	210 ～ 240
Nozzle Temperature	[deg.C]	210 ～ 230	220 ～ 240	230 ～ 240
Mold Temperature	[deg.C]	40 ～ 70		

Last update ： 1-Sep-2012