

--- MBS Resin ---

DENKA TH Polymer



Physical properties

Property	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
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
Temp of deflection under load	ISO 75-1, -2	1.8MPa Flatwise	deg.C	64	65	63
Vicat Softening Temp	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 Condition

	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 : 31-May-2016