

DENKA CL

Physical properties

Ptroperty	Test Methods	Conditions	Unit	CL-430
Melt Mass Flow Rate	ISO 1133	200deg.C 49N	g/10min	2.7
		220deg.C 98N		34
Tensile stress at yield	ISO 527-1, -2	50mm/min	MPa	42
Tensile stress at break			Mpa	31
Flexural Modulus	ISO 178	2mm/min	MPa	2,000
Flexural Strength			MPa	62
Charpy Impact Strength	ISO 179	Notched	kJ/m ²	14
Temp of deflection under load	ISO 75-1, -2	1.8MPa Flatwise	deg.C	64
Vicat Softening Temp	ISO 306	50N	deg.C	80
Rockwell Hardness	ISO 2039-2	M-scale	-	31
Density	ISO 1183	23 deg.C	kg/m ³	1,080
Light Transmission	ISO 13468-1	2mmt	%	91
Haze	ISO 14782	2mmt	%	2.0
Molding Shrinkage	DENKA Method	2mmt	%	0.4
Flammability	UL94 (UL File No.E49895)			HB

* The above values are typical and not guaranteed.

Injection Molding Condision

	Unit	CL-430
Pre-drying	Temp. [deg.C]	70 ~ 80
	Time [hr]	2 ~ 3
Cylinder Temperature	[deg.C]	210 ~ 220
Nozzle Temperature	[deg.C]	220 ~ 230
Mold Temperature	[deg.C]	40 ~ 70