

KumhoSunny PC/ABS HAC8250

Polycarbonate + ABS

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

PC/ABSHAC8250 is a high impact strength and high heat resistance PC/ABS resin.PC/ABSHAC8250 has been widely used in Auto and Household appliance,such as panel, car lamp and so on.

General Information			
Features	High Heat Resistance		
	High Impact Resistance		
Uses	Automotive Applications		
	Consumer Applications		
	Household Goods		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.13	g/cm ³	ISO 1183
Molding Shrinkage (23°C)	0.50 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	55.0	MPa	ISO 527-2/50
Flexural Modulus ¹	2200	MPa	ISO 178
Flexural Stress ²	72.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	32	kJ/m ²	
23°C	52	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)			ISO 179
No Break			
Notched Izod Impact Strength ⁵ (23°C)	50	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed)	105	°C	ISO 75-2/A
Vicat Softening Temperature	122	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093

Injection	Nominal Value	Unit
Drying Temperature	100 to 110	°C
Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	220 to 230	°C
Middle Temperature	240 to 250	°C
Front Temperature	260 to 270	°C
Nozzle Temperature	250 to 260	°C
Processing (Melt) Temp	250 to 270	°C
Mold Temperature	60.0 to 80.0	°C
Back Pressure	0.300 to 1.00	MPa
Screw Speed	30 to 70	rpm

NOTE

- | | |
|----|------------------|
| 1. | 2.0 mm/min |
| 2. | 2.0 mm/min |
| 3. | Condition: 4 J |
| 4. | Condition: 4 J |
| 5. | Condition: 5.5 J |
| 6. | 120°C/h |

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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