

KumhoSunny PC/ABS HAC8250Z

Polycarbonate + ABS

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

he HAC8250Z is usually used in the non-spraying parts with the fine or coarse striae.

General Information			
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	28	kJ/m ²	
23°C	48	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)			ISO 179
No Break			
Notched Izod Impact Strength ⁵ (23°C)	45	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
Optical	Nominal Value		Test Method
Gloss ⁷ (60°)	3 to 5		ISO 2813
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 |
| 7. | Grain |

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