

# KumhoSunny ABS HU650

Acrylonitrile Butadiene Styrene  
Shanghai KumhoSunny Plastics Co., Ltd.

Message:  
Kumhosunny ABSHU650 is heat resistance ABS with high rigidity , toughness and good UV stability.Application:Hair dryer shells,electric oven exterior parts and microwave ovens etc.

| General Information                                  |                                    |                   |              |
|------------------------------------------------------|------------------------------------|-------------------|--------------|
| Features                                             | Good Toughness                     |                   |              |
|                                                      | Good UV Resistance                 |                   |              |
|                                                      | High Heat Resistance               |                   |              |
|                                                      | High Rigidity                      |                   |              |
| Uses                                                 | Consumer Applications              |                   |              |
|                                                      | Electrical Parts                   |                   |              |
|                                                      | Electrical/Electronic Applications |                   |              |
| UL File Number                                       | E254819                            |                   |              |
|                                                      | E65424                             |                   |              |
| Forms                                                | Pellets                            |                   |              |
| Processing Method                                    | Injection Molding                  |                   |              |
| Physical                                             | Nominal Value                      | Unit              | Test Method  |
| Density (23°C)                                       | 1.06                               | g/cm <sup>3</sup> | ISO 1183     |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)            | 5.0                                | g/10 min          | ISO 1133     |
| Molding Shrinkage (23°C)                             | 0.40 to 0.70                       | %                 | ISO 294-4    |
| Hardness                                             | Nominal Value                      | Unit              | Test Method  |
| Rockwell Hardness (R-Scale, 23°C)                    | 115                                |                   | ISO 2039-2   |
| Mechanical                                           | Nominal Value                      | Unit              | Test Method  |
| Tensile Stress                                       | 45.0                               | MPa               | ISO 527-2/50 |
| Tensile Strain (Break)                               | 10                                 | %                 | ISO 527-2/50 |
| Flexural Modulus <sup>1</sup>                        | 2300                               | MPa               | ISO 178      |
| Flexural Stress <sup>2</sup>                         | 62.0                               | MPa               | ISO 178      |
| Poisson's Ratio <sup>3</sup>                         | 0.40                               |                   | ISO 527      |
| Impact                                               | Nominal Value                      | Unit              | Test Method  |
| Charpy Notched Impact Strength <sup>4</sup>          |                                    |                   | ISO 179      |
| -30°C                                                | 8.0                                | kJ/m <sup>2</sup> |              |
| 23°C                                                 | 14                                 | kJ/m <sup>2</sup> |              |
| Charpy Unnotched Impact Strength <sup>5</sup> (23°C) | 70                                 | kJ/m <sup>2</sup> | ISO 179      |

|                                                    |                  |                   |             |
|----------------------------------------------------|------------------|-------------------|-------------|
| Notched Izod Impact Strength <sup>6</sup>          |                  |                   | ISO 180     |
| -30°C                                              | 7.0              | kJ/m <sup>2</sup> |             |
| 23°C                                               | 13               | kJ/m <sup>2</sup> |             |
| Unnotched Izod Impact Strength <sup>7</sup> (23°C) |                  |                   | ISO 180     |
| Thermal                                            | Nominal Value    | Unit              | Test Method |
| Heat Deflection Temperature <sup>8</sup>           |                  |                   |             |
| 0.45 MPa, Unannealed                               | 105              | °C                | ISO 75-2/B  |
| 1.8 MPa, Unannealed                                | 96.0             | °C                | ISO 75-2/A  |
| Vicat Softening Temperature                        | 112              | °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   |
| Flammability                                       | Nominal Value    | Unit              | Test Method |
| Flame Rating                                       | HB               |                   | UL 94       |
| Injection                                          | Nominal Value    | Unit              |             |
| Drying Temperature                                 | 90.0 to 105      | °C                |             |
| Drying Time                                        | 3.0 to 4.0       | hr                |             |
| Suggested Max Moisture                             | 0.050            | %                 |             |
| Rear Temperature                                   | 220 to 240       | °C                |             |
| Middle Temperature                                 | 230 to 250       | °C                |             |
| Front Temperature                                  | 240 to 260       | °C                |             |
| Nozzle Temperature                                 | 250 to 270       | °C                |             |
| Processing (Melt) Temp                             | 240 to 260       | °C                |             |
| Mold Temperature                                   | 50.0 to 80.0     | °C                |             |
| Back Pressure                                      | 1.00 to 5.00     | MPa               |             |
| Screw Speed                                        | 30 to 70         | rpm               |             |
| NOTE                                               |                  |                   |             |
| 1.                                                 | 2.0 mm/min       |                   |             |
| 2.                                                 | 2.0 mm/min       |                   |             |
| 3.                                                 | 1mm/min          |                   |             |
| 4.                                                 | Condition: 4 J   |                   |             |
| 5.                                                 | Condition: 4 J   |                   |             |
| 6.                                                 | Condition: 5.5 J |                   |             |
| 7.                                                 | Condition: 5.5 J |                   |             |
| 8.                                                 | 120°C/h          |                   |             |

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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

