

KumhoSunny AES HW600G

Acrylonitrile Ethylene Styrene
Shanghai KumhoSunny Plastics Co., Ltd.

Message:

AESHW600G is a kind of AES resin with good weather resistance ability, offering high rigidity ,high toughness and excellent processability.
Application:automobile outside parts as side-mirror, radiator grill, etc.

General Information			
Features	Good Processability		
	Good Toughness		
	Good Weather Resistance		
	High Rigidity		
Uses	Automotive Applications		
	Automotive Exterior Parts		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
220°C/10.0 kg	17	g/10 min	ASTM D1238
220°C/10.0 kg	24	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.40 to 0.70	%	ASTM D955
--	0.40 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	52.0	MPa	ASTM D638
--	47.0	MPa	ISO 527-2/50
Tensile Elongation			
Break	22	%	ASTM D638
Break	25	%	ISO 527-2/50
Flexural Modulus			
--	2200	MPa	ASTM D790
-- ¹	2300	MPa	ISO 178
Flexural Strength			

--	72.0	MPa	ASTM D790
-- ²	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	7.0	kJ/m ²	
23°C	15	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)	60	kJ/m ²	ISO 179
Notched Izod Impact			
3.20 mm	200	J/m	ASTM D256
23°C ⁵	14	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	85.0	°C	ASTM D648
1.8 MPa, Unannealed ⁶	78.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	95.0	°C	ASTM D1525 ⁷
--	96.0	°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	80.0 to 95.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	200 to 220	°C	
Middle Temperature	210 to 230	°C	
Front Temperature	230 to 250	°C	
Nozzle Temperature	230 to 240	°C	
Processing (Melt) Temp	230 to 250	°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.	4J		
4.	4J		
5.	5.5J		
6.	120°C/h		

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