

KumhoSunny PMMA/ABS HAM8580

Acrylonitrile Butadiene Styrene + Acrylic (PMMA)

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HAM8580 is paint free improved PMMA/ABS resin.HAM8580 has comprehensive properties:(1)anti-scratch,PH=2H (2) high gloss(G60°>95)(3)super weather resistance(4)free style(black and spark,semitransparent,spark,transparent)(5)high without-gap tendency.HAM8580 is mainly used in auto exterior,etc.

General Information			
Features	Good Weather Resistance		
	High Gloss		
	Scratch Resistant		
Uses	Automotive Applications		
	Automotive Exterior Parts		
UL File Number	E254819		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	4.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	65.0	MPa	ASTM D638
Tensile Elongation (Break)	16	%	ASTM D638
Flexural Modulus	2600	MPa	ASTM D790
Flexural Strength	80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	45	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	95.0	°C	ASTM D648
Vicat Softening Temperature	105	°C	ASTM D1525 ¹
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	80.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	

Suggested Max Moisture	< 0.020	%
Rear Temperature	210 to 220	°C
Middle Temperature	220 to 230	°C
Front Temperature	240 to 260	°C
Nozzle Temperature	230 to 250	°C
Processing (Melt) Temp	235 to 245	°C
Mold Temperature	40.0 to 80.0	°C
Back Pressure	1.00 to 5.00	MPa
Screw Speed	30 to 60	rpm
NOTE		

1. Rate B (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

