

KumhoSunny PA/PPE HAP8720C

Polyamide + PPE

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HAP8720C is a conductive PA/PPE alloy especially designed for in- or on-line painted bodypanels and fenders in particular.

General Information			
Features	Conductive		
Uses	Automotive Applications		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.10	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	15	g/10 min	ISO 1133
Molding Shrinkage (23°C)	1.1 to 1.5	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	63.0	MPa	ISO 527-2/50
Tensile Strain (Break)	10	%	ISO 527-2/50
Flexural Modulus ¹ (64.0 mm)	2250	MPa	ISO 178
Flexural Stress ² (64.0 mm)	76.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	9.9	kJ/m ²	
23°C	20	kJ/m ²	
Charpy Unnotched Impact Strength ⁴			ISO 179
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength ⁵			ISO 180
-30°C	7.6	kJ/m ²	
23°C	14	kJ/m ²	
Unnotched Izod Impact Strength ⁶			ISO 180
-30°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷			
0.45 MPa, Unannealed	190	°C	ISO 75-2/B
1.8 MPa, Unannealed	110	°C	ISO 75-2/A

Vicat Softening Temperature	195	°C	ISO 306/B50
CLTE			ISO 11359-2
Flow : -40 to 40°C	9.0E-5	cm/cm/°C	
Transverse : -40 to 40°C	1.3E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+6	ohms	IEC 60093
Volume Resistivity	1.0E+5	ohms·cm	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature	99.0 to 105	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	270 to 300	°C	
Middle Temperature	275 to 300	°C	
Front Temperature	280 to 300	°C	
Processing (Melt) Temp	285 to 305	°C	
Mold Temperature	60.0 to 90.0	°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. Condition: 4 J
4. Condition: 4 J
5. Condition: 5.5 J
6. Condition: 5.5 J
7. 120°C/h

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