

KumhoSunny PC/ABS HAC8250TC

Polycarbonate + ABS

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HAC8250TC is a good dimensional stability mineral filled PC/ABS resin

General Information			
Filler / Reinforcement	Mineral		
Features	Good Dimensional Stability		
	High Heat Resistance		
	High Impact Resistance		
Uses	Automotive Applications		
	Automotive Exterior Parts		
	Automotive Interior Parts		
	Power/Other Tools		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/10.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage			
Flow	0.30 to 0.50	%	ASTM D955
--	0.40 to 0.60	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	55.0	MPa	ASTM D638
--	52.0	MPa	ISO 527-2/5
Tensile Elongation (Break)	30	%	ASTM D638
Flexural Modulus			
--	2700	MPa	ASTM D790
-- ¹	2500	MPa	ISO 178
Flexural Strength			
--	80.0	MPa	ASTM D790
-- ²	75.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	10	kJ/m ²	
23°C	30	kJ/m ²	
Notched Izod Impact			
3.20 mm	400	J/m	ASTM D256
23°C ⁴	25	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	100	°C	ASTM D648
1.8 MPa, Unannealed ⁵	103	°C	ISO 75-2/A
Vicat Softening Temperature	115	°C	ISO 306/B50, ASTM D1525 ⁶
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 (1.60 mm)	HB		UL 94
Additional Information	Nominal Value		
CSA File No.	LS 66457		
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	230 to 250	°C	
Middle Temperature	240 to 260	°C	
Front Temperature	260 to 270	°C	
Nozzle Temperature	250 to 260	°C	
Processing (Melt) Temp	260 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.	4J		
4.	5.5J		
5.	120°C/h		
6.	Rate B (120°C/h)		

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