

KumhoSunny PC/AES HEC0245

Acrylonitrile Ethylene Styrene + PC
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
HEC0245 is a high flow PC/AES resin.

General Information			
Features	Flame Retardant		
	High Flow		
	High Heat Resistance		
Uses	Automotive Applications		
	Thin-walled Parts		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.08	g/cm ³	ASTM D792
--	1.12	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/10.0 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage			
Flow	0.50 to 0.70	%	ASTM D955
--	0.50 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	53.0	MPa	ASTM D638
--	50.0	MPa	ISO 527-2/50
Tensile Elongation (Break)	60	%	ASTM D638
Flexural Modulus			
--	1900	MPa	ASTM D790
-- ¹	2000	MPa	ISO 178
Flexural Strength			
--	70.0	MPa	ASTM D790
-- ²	63.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength ³			ISO 179
-30°C	32	kJ/m ²	
23°C	48	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)			ISO 179
No Break			
Notched Izod Impact			
3.20 mm	500	J/m	ASTM D256
23°C ⁵	45	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 ⁶	96.0	°C	ISO 75-2/A
Vicat Softening Temperature	110	°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
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	220 to 230	°C	
Middle Temperature	230 to 240	°C	
Front Temperature	250 to 260	°C	
Nozzle Temperature	240 to 250	°C	
Processing (Melt) Temp	240 to 260	°C	
Mold Temperature	50.0 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.	4J		
5.	5.5J		
6.	120°C/h		

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