

# Kingfa MAC-451

Polycarbonate + ABS

Kingfa

## Message:

Kingfa MAC-451 is a polycarbonate acrylonitrile butadiene styrene (PC ABS) material. This product is available in North America or Asia Pacific region. The processing method is injection molding.

The main features of Kingfa MAC-451 are:

- flame retardant/rated flame
- Good processability
- Impact resistance

Typical application areas include:

- Automotive Industry
- Electrical/electronic applications
- electrical appliances
- Wire and cable
- home apps

General Information			
Features	Impact resistance, good		
	Electroplateable		
	Workability, good		
Uses	Computer components		
	Electrical appliances		
	Household goods		
	Car interior equipment		
	Car exterior decoration		
	Communication Equipment		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage			ASTM D955
Flow: 23°C	0.40 - 0.60	%	ASTM D955
Transverse flow: 23°C	0.40 - 0.60	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup>	50.0	MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	60	%	ASTM D638
Flexural Modulus <sup>3</sup>	2250	MPa	ASTM D790
Flexural Strength <sup>4</sup>	75.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	500	J/m	ASTM D256
Unnotched Izod Impact (23°C, 3.20 mm)	No Break		ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	112	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	100	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0 - 100	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	210 - 230	°C	
Middle Temperature	220 - 240	°C	
Front Temperature	225 - 245	°C	
Processing (Melt) Temp	220 - 240	°C	
Mold Temperature	40.0 - 80.0	°C	
Back Pressure	0.300 - 1.00	MPa	
Injection instructions			
Processing Temperature Limit: 250°C Injection Speed: 40 to 80%			
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		

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