

KumhoSunny PA/ABS HNA0370

Acrylonitrile Butadiene Styrene + Nylon

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HNA 0370 has the feature of high impact.

General Information			
Features	Good Chemical Resistance		
	Good Weather Resistance		
	High Flow		
	High Heat Resistance		
	Low Density		
	Low Gloss		
Uses	Automotive Applications		
	Automotive Exterior Parts		
	Automotive Interior Parts		
	Electrical Parts		
	Electrical/Electronic Applications		
	Power/Other Tools		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.11	g/cm ³	ASTM D792
--	1.09	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
240°C/10.0 kg	45 to 60	g/10 min	ASTM D1238
240°C/10.0 kg	60	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.60 to 0.80	%	ASTM D955
--	0.60 to 0.80	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	48.0	MPa	ASTM D638
--	50.0	MPa	ISO 527-2/50

Tensile Elongation (Break)	40	%	ASTM D638
Flexural Modulus			
--	1800	MPa	ASTM D790
-- ¹	1600	MPa	ISO 178
Flexural Strength			
--	72.0	MPa	ASTM D790
-- ²	60.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	6.0	kJ/m ²	
23°C	25	kJ/m ²	
Notched Izod Impact			
3.20 mm	200	J/m	ASTM D256
23°C ⁴	20	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	102	°C	ASTM D648
1.8 MPa, Unannealed ⁵	65.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	112	°C	ASTM D1525 ⁶
--	115	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+14	ohms	IEC 60093
Volume Resistivity	> 1.0E+14	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
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	190 to 210	°C	
Middle Temperature	210 to 230	°C	
Front Temperature	210 to 230	°C	
Nozzle Temperature	220 to 240	°C	
Processing (Melt) Temp	220 to 230	°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.	4J		

4.	5.5J
5.	120°C/h
6.	Rate B (120°C/h)

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