

KumhoSunny PBT/PET HEB4050M

Polybutylene Terephthalate + PET

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HEB4050M is a mineral filled PBT/PET alloy resin, offering good mechanical properties, outstanding appearance, very low haze and excellent processing properties. HEB4050M is recommended for headlight lamp,such as bezel,etc.

General Information			
Features	Good Processability		
	Good Processing Stability		
Uses	Consumer Applications		
	Lighting Applications		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.45	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	20	g/10 min	ISO 1133
Molding Shrinkage (23°C)	1.2 to 1.5	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	45.0	MPa	ISO 527-2/5
Flexural Modulus ¹	3600	MPa	ISO 178
Flexural Stress ²	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	3.5	kJ/m ²	
23°C	5.5	kJ/m ²	
Notched Izod Impact Strength (23°C)	5.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ³ (0.45 MPa, Unannealed)	200	°C	ISO 75-2/B
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	100 to 120	°C	

Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	230 to 240	°C
Middle Temperature	240 to 250	°C
Front Temperature	250 to 255	°C
Nozzle Temperature	255 to 265	°C
Processing (Melt) Temp	245 to 265	°C
Mold Temperature	70.0 to 80.0	°C
Back Pressure	0.200 to 0.800	MPa
Screw Speed	20 to 100	rpm

NOTE

1. 2.0 mm/min
2. 2.0 mm/min
3. 120°C/h

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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