

KumhoSunny PC HCG2530MP

Polycarbonate

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HCG2530MP is high rigidity and balance tenacity 30%GF PC resin. It has excellent surface, high NCVM rate, easy to machining, high stability and super shape resistance property. HCG2530MP is mainly used in mobile phone

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Good Stability		
	Good Surface Finish		
	High Rigidity		
	Machinable		
Uses	Cell Phones		
UL File Number	E254819		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	16	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.10 to 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	120	MPa	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	7500	MPa	ASTM D790
Flexural Strength	180	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	138	°C	ASTM D648
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
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	

Rear Temperature	250 to 270	°C
Middle Temperature	260 to 280	°C
Front Temperature	280 to 300	°C
Nozzle Temperature	280 to 290	°C
Processing (Melt) Temp	290 to 300	°C
Mold Temperature	100 to 140	°C
Back Pressure	0.300 to 1.00	MPa
Screw Speed	20 to 100	rpm

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