

KumhoSunny PC/ABS HAC5020G

Polycarbonate + ABS

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HAC5020G is a good dimensional stability glass fiber reinforced PC/ABS resin.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Good Dimensional Stability		
Uses	Business Equipment		
	Printer		
	Printer Parts		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.30	g/cm ³	ASTM D792
--	1.28	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/10.0 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage			
Flow	0.20 to 0.40	%	ASTM D955
--	0.20 to 0.40	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	100	MPa	ASTM D638, ISO 527-2/5
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus			
--	5400	MPa	ASTM D790
-- ¹	5400	MPa	ISO 178
Flexural Strength			
--	140	MPa	ASTM D790
-- ²	140	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	8.0	kJ/m ²	ISO 179
Notched Izod Impact			
3.20 mm	120	J/m	ASTM D256

23°C ⁴	7.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	128	°C	ASTM D648
1.8 MPa, Unannealed ⁵	120	°C	ISO 75-2/A
Vicat Softening Temperature			
--	122	°C	ASTM D1525 ⁶
--	128	°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
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	110 to 120	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	220 to 240	°C	
Middle Temperature	240 to 260	°C	
Front Temperature	270 to 280	°C	
Nozzle Temperature	260 to 270	°C	
Processing (Melt) Temp	270 to 280	°C	
Mold Temperature	60.0 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.	5.5J		
5.	120°C/h		
6.	Rate B (120°C/h)		

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