

Kingfa HR-527

Acrylonitrile Butadiene Styrene

Kingfa

Message:

Kingfa HR-527 is an acrylonitrile butadiene styrene (ABS) material. This product is available in North America or Asia Pacific region. The processing method is injection molding.

The main features of Kingfa HR-527 are:

flame retardant/rated flame

Impact resistance

The typical application field of Kingfa HR-527 is: automotive industry

General Information			
UL YellowCard	E171666-225718		
Features	Impact resistance, good		
Uses	Car interior parts		
	Car interior equipment		
	Automotive exterior parts		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	1.8	g/10 min	ASTM D1238
220°C/10.0 kg	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C)	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	45.0	MPa	ASTM D638
Tensile Elongation ² (Break)	20	%	ASTM D638
Flexural Modulus ³	2400	MPa	ASTM D790
Flexural Strength ⁴	68.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	240	J/m	ASTM D256
23°C, 6.40 mm	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	99.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	90.0	°C	ASTM D648
Vicat Softening Temperature			

--	105	°C	ASTM D1525 ⁵
--	96.0	°C	ASTM D1525 ⁶
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength	23	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	HB		UL 94
3.20 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	180 - 205	°C	
Middle Temperature	205 - 230	°C	
Front Temperature	215 - 240	°C	
Processing (Melt) Temp	220 - 245	°C	
Mold Temperature	30.0 - 60.0	°C	
Injection Rate	Slow-Moderate		
Back Pressure	0.00 - 0.0100	MPa	
Injection instructions			
Processing Temperature Limit: 250°C			
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		
5.	标准 B (120°C/h), 压力 1 (10N)		
6.	速率 A (50°C/h), 载荷 2 (50N)		

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