

Color-in™ HAC-M

Polycarbonate + ABS

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HAC-M is injection a molding aesthetic resin.HAC-M is a color creativity plan.HAC-M is mainly used in appearance items of household appliance,etc.

General Information			
Features	Pleasing Surface Appearance		
Uses	Appliances		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	50	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Pencil Hardness - 500g	HB		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	60.0	MPa	ASTM D638
Flexural Modulus	2300	MPa	ASTM D790
Flexural Strength	78.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	85.0	°C	ASTM D648
Vicat Softening Temperature	95.0	°C	ASTM D1525 ¹
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)	V-0		UL 94
Optical	Nominal Value		Test Method
Gardner Gloss	> 90		ASTM D523
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 110	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.030	%	
Rear Temperature	210 to 240	°C	

Middle Temperature	220 to 245	°C
Front Temperature	230 to 255	°C
Nozzle Temperature	230 to 250	°C
Processing (Melt) Temp	240 to 250	°C
Mold Temperature	85.0 to 95.0	°C
Back Pressure	0.300 to 1.00	MPa
Screw Speed	40 to 55	rpm

NOTE

1. Rate B (120°C/h)

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