

KumhoSunny PC/ABS HAC8265P

Polycarbonate + ABS

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

PC/ABSHAC8265P is a high chemical resistance and super high heat resistance PC/ABS resin.PC/ABSHAC8265P has been widely used in Auto exterior parts, such as handle , hubcap and so on.

General Information			
Features	Good Chemical Resistance		
	High Heat Resistance		
Uses	Automotive Applications		
	Automotive Exterior Parts		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.14	g/cm ³	ISO 1183
Molding Shrinkage (23°C)	0.50 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	58.0	MPa	ISO 527-2/50
Flexural Modulus ¹	2300	MPa	ISO 178
Flexural Stress ²	76.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	35	kJ/m ²	
23°C	55	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)			ISO 179
No Break			
Notched Izod Impact Strength ⁵ (23°C)	52	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed)	110	°C	ISO 75-2/A
Vicat Softening Temperature	125	°C	ISO 306/B50
Injection	Nominal Value	Unit	
Drying Temperature	100 to 110	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.020	%	

Rear Temperature	220 to 230	°C
Middle Temperature	240 to 250	°C
Front Temperature	260 to 270	°C
Nozzle Temperature	250 to 260	°C
Processing (Melt) Temp	250 to 270	°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. | Condition: 4 J |
| 4. | Condition: 4 J |
| 5. | Condition: 5.5 J |
| 6. | 120°C/h |

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