

KumhoSunny PPO HSP8344

Polyphenylene Ether + PS
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
HSP8344 is a high impact PS/PPE alloy designed for automobile exterior/interior parts.

General Information			
Features	Good Creep Resistance		
	High Impact Resistance		
	Low to No Water Absorption		
Uses	Automotive Applications		
	Automotive Exterior Parts		
	Automotive Interior Parts		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.04	g/cm ³	ASTM D792
--	1.05	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
220°C/10.0 kg	10 to 14	g/10 min	ASTM D1238
280°C/5.0 kg	10	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.50 to 0.70	%	ASTM D955
--	0.40 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	43.0	MPa	ASTM D638
--	45.0	MPa	ISO 527-2/50
Tensile Elongation			
Break	70	%	ASTM D638
Break	82	%	ISO 527-2/50
Flexural Modulus			
--	1820	MPa	ASTM D790
-- ¹	1920	MPa	ISO 178

Flexural Strength			
--	60.0	MPa	ASTM D790
-- ²	59.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	38	kJ/m ²	
23°C	20	kJ/m ²	
Charpy Unnotched Impact Strength ⁴			ISO 179
-30°C	No Break		
23°C	No Break		
Notched Izod Impact			
3.20 mm	510	J/m	ASTM D256
-30°C ⁵	18	kJ/m ²	ISO 180
23°C ⁶	36	kJ/m ²	ISO 180
Unnotched Izod Impact Strength ⁷			ISO 180
-30°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed ⁸	120	°C	ISO 75-2/B
1.8 MPa, Unannealed	113	°C	ASTM D648
1.8 MPa, Unannealed ⁹	110	°C	ISO 75-2/A
Vicat Softening Temperature			
--	120	°C	ASTM D1525 ¹⁰
--	122	°C	ISO 306/B50
CLTE			ISO 11359-2
Flow : -40 to 40°C	6.6E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.6E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+14	ohms	IEC 60093
Volume Resistivity	> 1.0E+14	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	230 to 250	°C	
Middle Temperature	250 to 270	°C	
Front Temperature	255 to 275	°C	
Nozzle Temperature	260 to 275	°C	
Processing (Melt) Temp	260	°C	

Mold Temperature	60.0 to 90.0	°C
Back Pressure	1.00 to 5.00	MPa
Screw Speed	30 to 70	rpm

NOTE

1.	2.0 mm/min
2.	2.0 mm/min
3.	4J
4.	4J
5.	5.5J
6.	5.5J
7.	5.5J
8.	120°C/h
9.	120°C/h
10.	Rate B (120°C/h)

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