

KumhoSunny PC HCG2510MP

Polycarbonate

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HCG2510MP is high rigidity and high tenacity 10%GF PC resin. It has high stability and super shape resistance property. HCG2510MP is mainly used in mobile phone housing, etc.

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Features	Good Stability		
	High Rigidity		
Uses	Cell Phones		
	Housings		
UL File Number	E254819		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.20 to 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	59.0	MPa	ASTM D638
Tensile Elongation (Break)	9.0	%	ASTM D638
Flexural Modulus	3250	MPa	ASTM D790
Flexural Strength	98.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	140	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	135	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms · cm	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	250 to 270	°C	
Middle Temperature	260 to 280	°C	

Front Temperature	280 to 300	°C
Nozzle Temperature	280 to 290	°C
Processing (Melt) Temp	290 to 300	°C
Mold Temperature	100 to 140	°C
Back Pressure	0.300 to 1.00	MPa
Screw Speed	20 to 100	rpm

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Recommended distributors for this material

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