

KumhoSunny ABS HU621

Acrylonitrile Butadiene Styrene
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
Kumhosunny ABSHU621 is heat resistance ABS with high rigidity ,high impact properties, toughness and good UV stability.Application:Hair dryer shells,electric oven exterior parts and microwave ovens etc.

General Information			
Features	Good Impact Resistance		
	Good Toughness		
	Good UV Resistance		
	High Heat Resistance		
	High Rigidity		
Uses	Consumer Applications		
	Electrical Parts		
	Electrical/Electronic Applications		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	6.0	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 to 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	105		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	42.0	MPa	ISO 527-2/50
Tensile Strain (Break)	20	%	ISO 527-2/50
Flexural Modulus ¹	2200	MPa	ISO 178
Flexural Stress ²	60.0	MPa	ISO 178
Poisson's Ratio ³	0.39		ISO 527
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁴			ISO 179
-30°C	14	kJ/m ²	
23°C	25	kJ/m ²	

Charpy Unnotched Impact Strength ⁵ (23°C)	No Break		ISO 179
Notched Izod Impact Strength ⁶			ISO 180
-30°C	13	kJ/m ²	
23°C	24	kJ/m ²	
Unnotched Izod Impact Strength ⁷ (23°C)	No Break		ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁸			
0.45 MPa, Unannealed	94.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	83.0	°C	ISO 75-2/A
Vicat Softening Temperature	102	°C	ISO 306/B50
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	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 95.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	190 to 210	°C	
Middle Temperature	210 to 220	°C	
Front Temperature	220 to 235	°C	
Nozzle Temperature	230 to 245	°C	
Processing (Melt) Temp	230 to 250	°C	
Mold Temperature	50.0 to 80.0	°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.	1mm/min		
4.	Condition: 4 J		
5.	Condition: 4 J		
6.	Condition: 5.5 J		
7.	Condition: 5.5 J		
8.	120°C/h		

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