

KumhoSunny PC/AES HEC0275

Acrylonitrile Ethylene Styrene + PC
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
HEC0275 is a high heat resistance PC/AES resin.

General Information			
Features	Flame Retardant		
	High Flow		
	High Impact Resistance		
	Medium Heat Resistance		
Uses	Automotive Applications		
	Electrical Parts		
	Electrical/Electronic Applications		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/10.0 kg)	13	g/10 min	ASTM D1238
Molding Shrinkage			
Flow	0.50 to 0.70	%	ASTM D955
--	0.50 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	60.0	MPa	ASTM D638
--	58.0	MPa	ISO 527-2/50
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus			
--	2200	MPa	ASTM D790
-- ¹	2200	MPa	ISO 178
Flexural Strength			
--	80.0	MPa	ASTM D790
-- ²	75.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength ³			ISO 179
-30°C	32	kJ/m ²	
23°C	50	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)			ISO 179
No Break			
Notched Izod Impact			
3.20 mm	700	J/m	ASTM D256
23°C ⁵	48	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	110	°C	ASTM D648
1.8 MPa, Unannealed ⁶	108	°C	ISO 75-2/A
Vicat Softening Temperature	120	°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
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 240	°C	
Middle Temperature	240 to 260	°C	
Front Temperature	260 to 270	°C	
Nozzle Temperature	250 to 260	°C	
Processing (Melt) Temp	250 to 270	°C	
Mold Temperature	50.0 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.	4J		
4.	4J		
5.	5.5J		
6.	120°C/h		

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