

KumhoSunny PPO HSP8340

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

Message:
HSP8340 is a general-use PS/PPE alloy designed for automobile exterior/interior parts.

General Information			
Features	General Purpose		
	Good Creep Resistance		
	Low to No Water Absorption		
Uses	Appliance Components		
	Appliances		
	Automotive Applications		
	Automotive Exterior Parts		
	Automotive Interior Parts		
	Electrical/Electronic Applications		
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	12 to 16	g/10 min	ASTM D1238
280°C/5.0 kg	16	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			
--	50.0	MPa	ASTM D638
--	48.0	MPa	ISO 527-2/50
Tensile Elongation			
Break	50	%	ASTM D638
Break	42	%	ISO 527-2/50

Flexural Modulus			
--	2000	MPa	ASTM D790
-- ¹	2120	MPa	ISO 178
Flexural Strength			
--	63.0	MPa	ASTM D790
-- ²	62.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	35	kJ/m ²	
23°C	18	kJ/m ²	
Charpy Unnotched Impact Strength ⁴			ISO 179
-30°C	No Break		
23°C	No Break		
Notched Izod Impact			
3.20 mm	430	J/m	ASTM D256
-30°C ⁵	16	kJ/m ²	ISO 180
23°C ⁶	29	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	125	°C	ISO 75-2/B
1.8 MPa, Unannealed	113	°C	ASTM D648
1.8 MPa, Unannealed ⁹	115	°C	ISO 75-2/A
Vicat Softening Temperature	126	°C	ISO 306/B50, ASTM D1525 ¹⁰
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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