

Kingfa MAC-851

Polycarbonate + ABS

Kingfa

Message:

Kingfa MAC-851 is a polycarbonate acrylonitrile butadiene styrene (PC ABS) material. This product is available in North America or Asia Pacific region. The processing method is injection molding.

The main features of Kingfa MAC-851 are:

flame retardant/rated flame

Good processability

Impact resistance

Typical application areas include:

Electrical/electronic applications

electrical appliances

engineering/industrial accessories

home apps

Automotive Industry

General Information			
UL YellowCard	E171666-225750		
Features	Ultra-high impact resistance		
	Gloss, Medium		
	Electroplateable		
	Workability, good		
Uses	Thin wall parts		
	Computer components		
	Electrical components		
	Home appliance components		
	Household goods		
	Car dashboard		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.16	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C)	0.50 - 0.70	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	55.0	MPa	ASTM D638
Tensile Elongation ² (Break)	60	%	ASTM D638
Flexural Modulus ³	2400	MPa	ASTM D790

Flexural Strength ⁴	85.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-32°C, 3.20 mm	400	J/m	ASTM D256
23°C, 3.20 mm	600	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	135	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	123	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	100 - 110	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	220 - 245	°C	
Middle Temperature	220 - 250	°C	
Front Temperature	230 - 260	°C	
Processing (Melt) Temp	220 - 260	°C	
Mold Temperature	40.0 - 80.0	°C	
Back Pressure	0.300 - 1.00	MPa	
Injection instructions			
Processing Temperature Limit: 265°C Injection Speed: 60 to 90%			
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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