

Kingfa FW-650

Acrylonitrile Butadiene Styrene

Kingfa

Message:

Kingfa FW-650 is an acrylonitrile butadiene styrene (ABS) material. This product is available in North America or Asia Pacific region. The processing method is injection molding.

The main features of Kingfa FW-650 are:

Impact resistance

good weather resistance

The typical application areas of Kingfa FW-650 are: electrical/electronic applications

General Information			
Features	Ultra-high impact resistance		
	Good weather resistance		
Uses	Membrane key switch		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	2.0	g/10 min	ASTM D1238
220°C/10.0 kg	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C)	0.40 - 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	37.0	MPa	ASTM D638
Tensile Elongation ² (Break)	20	%	ASTM D638
Flexural Modulus ³	2000	MPa	ASTM D790
Flexural Strength ⁴	56.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	310	J/m	ASTM D256
23°C, 6.40 mm	290	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	87.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	78.0	°C	ASTM D648
Vicat Softening Temperature			
--	101	°C	ASTM D1525 ⁵
--	91.0	°C	ASTM D1525 ⁶

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength	23	kV/mm	ASTM D149

Additional Information

Flammability, IEC 60695: 750°CWeather Resistance, ASTM D4459, 300hr xenon lamp: <3 delta E

Injection	Nominal Value	Unit
Drying Temperature	70.0 - 80.0	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	180 - 210	°C
Middle Temperature	190 - 220	°C
Front Temperature	200 - 230	°C
Processing (Melt) Temp	200 - 230	°C
Mold Temperature	30.0 - 60.0	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.00 - 0.0100	MPa

Injection instructions

Processing Temperature Limit: 245°C

NOTE

- | | |
|----|----------------------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 2.0 mm/min |
| 4. | 2.0 mm/min |
| 5. | 标准 B (120°C/h), 压力 1 (10N) |
| 6. | 速率 A (50°C/h), 载荷 2 (50N) |

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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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