

Kingfa HF-618

Acrylonitrile Butadiene Styrene

Kingfa

Message:

Kingfa HF-618 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 HF-618 are:

flame retardant/rated flame

Good toughness

Typical application areas include:

electrical appliances

House

General Information			
Features	Ultra high toughness		
	Good liquidity		
Uses	Electrical appliances		
	Shell		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
200°C/5.0 kg	3.5	g/10 min	ASTM D1238
220°C/10.0 kg	40	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C)	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	40.0	MPa	ASTM D638
Tensile Elongation ² (Break)	15	%	ASTM D638
Flexural Modulus ³	2000	MPa	ASTM D790
Flexural Strength ⁴	60.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	200	J/m	ASTM D256
23°C, 6.40 mm	190	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	77.0	°C	ASTM D648
Vicat Softening Temperature			
--	95.0	°C	ASTM D1525 ⁵
--	85.0	°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
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	V-0		UL 94
3.00 mm	V-0		UL 94
2.00 mm	5VB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 80.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	160 - 180	°C	
Middle Temperature	170 - 190	°C	
Front Temperature	180 - 210	°C	
Processing (Melt) Temp	170 - 210	°C	
Mold Temperature	30.0 - 60.0	°C	
Injection Rate	Slow-Moderate		
Back Pressure	0.00 - 0.0100	MPa	
Injection instructions			
Processing Temperature Limit: 230°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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