

KumhoSunny ABS HFA456

Acrylonitrile Butadiene Styrene

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HFA456 is non-halogenand enviromental ABS resin. It has balance flow properties,mechanical properties and heat resistance. HFA456 is mainly used in consumer electronics as camcorder, digital camera, PSP etc.

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
	Halogen Free		
Uses	Camera Applications		
	Electrical/Electronic Applications		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	65	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	45.0	MPa	ASTM D638
Tensile Elongation (Break)	25	%	ASTM D638
Flexural Modulus	2300	MPa	ASTM D790
Flexural Strength	60.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	250	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	76.0	°C	ASTM D648
Vicat Softening Temperature	86.0	°C	ASTM D1525 ¹
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			UL 94

1.60 mm	V-2	
2.10 mm	V-2	
3.20 mm	V-2	
Additional Information		Nominal Value
CSA File No.	LS 66457	
Injection	Nominal Value	Unit
Drying Temperature	80.0 to 90.0	°C
Drying Time	2.0 to 3.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	190 to 200	°C
Middle Temperature	190 to 200	°C
Front Temperature	200 to 210	°C
Nozzle Temperature	200 to 210	°C
Processing (Melt) Temp	200 to 210	°C
Mold Temperature	40.0 to 80.0	°C
Back Pressure	1.00 to 5.00	MPa
Screw Speed	30 to 60	rpm
NOTE		
1.	Rate B (120°C/h)	

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