

KumhoSunny PA/PPE HAP8720G

Polyamide + PPE

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HAP8720G is a 20% glass reinforced PA66/PPE alloy.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.21	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	35	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.70 to 1.1	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	100	MPa	ISO 527-2/50
Tensile Strain (Break)	4.5	%	ISO 527-2/50
Flexural Modulus ¹ (64.0 mm)	5000	MPa	ISO 178
Flexural Stress ² (64.0 mm)	160	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	17	kJ/m ²	
23°C	8.1	kJ/m ²	
Charpy Unnotched Impact Strength ⁴			ISO 179
-30°C	6.4	kJ/m ²	
23°C	97	kJ/m ²	
Notched Izod Impact Strength ⁵			ISO 180
-30°C	7.2	kJ/m ²	
23°C	16	kJ/m ²	
Unnotched Izod Impact Strength ⁶			ISO 180
-30°C	5.6	kJ/m ²	
23°C	96	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷			
0.45 MPa, Unannealed	226	°C	ISO 75-2/B
1.8 MPa, Unannealed	156	°C	ISO 75-2/A
Vicat Softening Temperature	230	°C	ISO 306/B50

Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature	99.0 to 105	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	270 to 300	°C	
Middle Temperature	275 to 305	°C	
Front Temperature	280 to 305	°C	
Nozzle Temperature	285 to 305	°C	
Processing (Melt) Temp	285 to 305	°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. | Condition: 4 J |
| 4. | Condition: 4 J |
| 5. | Condition: 5.5 J |
| 6. | Condition: 5.5 J |
| 7. | 120°C/h |

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