

KumhoSunny ABS HFA705G

Acrylonitrile Butadiene Styrene

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HFA705G is high gloss,paint free enviromental flame retardant ABS resin. It has high weather resistance and heat resistance properties. HFA705G is mainly used in frame and base of TV, sound panel,etc.

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Weather Resistance		
	High Gloss		
	High Heat Resistance		
Uses	Electrical/Electronic Applications		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	45	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	40.0	MPa	ASTM D638
Tensile Elongation (Break)	15	%	ASTM D638
Flexural Modulus	2000	MPa	ASTM D790
Flexural Strength	55.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	80.0	°C	ASTM D648
Vicat Softening Temperature	90.0	°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-1	
2.10 mm	V-0	
3.20 mm	V-0	
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	165 to 175	°C
Middle Temperature	185 to 195	°C
Front Temperature	200 to 210	°C
Nozzle Temperature	195 to 205	°C
Processing (Melt) Temp	200 to 220	°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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