

KumhoSunny PC/PBT HCB9230

Polycarbonate + PBT

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HCB9230 is a high flow and high heat resistance PC/PBT alloy resin, offering high impact and good chemical resistance.HCB9230 is recommended for auto outside laggage carrier,handle, ectron & electric parts etc.

General Information			
Features	Good Chemical Resistance		
	High Flow		
	High Heat Resistance		
	High Impact Resistance		
Uses	Automotive Applications		
	Electrical Parts		
	Electrical/Electronic Applications		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
250°C/5.0 kg	13	g/10 min	ASTM D1238
250°C/5.0 kg	15	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.60 to 0.90	%	ASTM D955
--	0.60 to 0.90	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	63.0	MPa	ASTM D638
--	56.0	MPa	ISO 527-2/50
Tensile Elongation (Break)	120	%	ASTM D638
Flexural Modulus			
--	2200	MPa	ASTM D790
-- ¹	2100	MPa	ISO 178
Flexural Strength			
--	87.0	MPa	ASTM D790

-- ²	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	30	kJ/m ²	
23°C	55	kJ/m ²	
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Notched Izod Impact			
3.20 mm	820	J/m	ASTM D256
23°C	55	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	107	°C	ASTM D648
1.8 MPa, Unannealed ³	98.0	°C	ISO 75-2/A
Vicat Softening Temperature	115	°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	100 to 110	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	230 to 260	°C	
Middle Temperature	240 to 270	°C	
Front Temperature	240 to 270	°C	
Nozzle Temperature	245 to 265	°C	
Processing (Melt) Temp	240 to 270	°C	
Mold Temperature	50.0 to 80.0	°C	
Back Pressure	0.300 to 1.00	MPa	
Screw Speed	30 to 70	rpm	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	120°C/h		

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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

