

Kingplate™ HAC8244H

Polycarbonate + ABS

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

PC/ABSHAC8244H is a high flow and heat resistance plating grade PC/ABS resin.PC/ABSHAC8244H has been widely used in automotive interior and exterior parts, such as handle, condenser and so on.

General Information			
Features	High Flow		
	High Heat Resistance		
	Platable		
Uses	Automotive Applications		
	Automotive Exterior Parts		
	Automotive Interior Parts		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.10	g/cm ³	ISO 1183
Molding Shrinkage (23°C)	0.50 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	47.0	MPa	ISO 527-2/50
Flexural Modulus ¹	2000	MPa	ISO 178
Flexural Stress ²	56.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	36	kJ/m ²	
23°C	52	kJ/m ²	
Charpy Unnotched Impact Strength ⁴ (23°C)			ISO 179
No Break			
Notched Izod Impact Strength ⁵ (23°C)	50	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed)	98.0	°C	ISO 75-2/A
Vicat Softening Temperature	110	°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	95.0 to 105	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	220 to 230	°C	
Middle Temperature	230 to 240	°C	
Front Temperature	240 to 265	°C	
Nozzle Temperature	240 to 250	°C	
Processing (Melt) Temp	245 to 255	°C	
Mold Temperature	60.0 to 90.0	°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.	Condition: 4 J		
4.	Condition: 4 J		
5.	Condition: 5.5 J		
6.	120°C/h		

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