

KumhoSunny ABS HU600-P

Acrylonitrile Butadiene Styrene
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
ABSHU600-P is a high heat resistance ABS resin for plating , offering high rigidity and high impact.

General Information			
Features	High Heat Resistance		
	High Impact Resistance		
	High Rigidity		
	Platable		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.05	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	6.0	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	42.0	MPa	ISO 527-2/50
Tensile Strain (Break)	65	%	ISO 527-2/50
Flexural Modulus ¹ (64.0 mm)	2350	MPa	ISO 178
Flexural Stress ² (64.0 mm)	65.0	MPa	ISO 178
Poisson's Ratio	0.39		ISO 527
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	11	kJ/m ²	
23°C	24	kJ/m ²	
Charpy Unnotched Impact Strength ⁴			ISO 179
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength ⁵			ISO 180
-30°C	10	kJ/m ²	
23°C	21	kJ/m ²	
Unnotched Izod Impact Strength ⁶			ISO 180
-30°C	No Break		

23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷			
0.45 MPa, Unannealed	105	°C	ISO 75-2/B
1.8 MPa, Unannealed	90.0	°C	ISO 75-2/A
Vicat Softening Temperature	111	°C	ISO 306/B50
CLTE			ISO 11359-2
Flow : -40 to 40°C	7.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.6E-5	cm/cm/°C	
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	85.0 to 100	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	200 to 220	°C	
Middle Temperature	230 to 240	°C	
Front Temperature	240 to 250	°C	
Nozzle Temperature	250 to 260	°C	
Processing (Melt) Temp	250 to 260	°C	
Mold Temperature	50.0 to 80.0	°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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