

C-Clear™ K7050

Acrylonitrile Butadiene Styrene
Shanghai KumhoSunny Plastics Co., Ltd.

Message:

Kumhosunny C-Clear™ K7050 is heat resistance ABS with low VOC ,high rigidity , toughness and good UV-stability .

General Information			
Features	Good Toughness		
	Good UV Resistance		
	High Heat Resistance		
	High Rigidity		
	Low VOC		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.06	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	8.0	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 to 0.70	%	ISO 294-4
VOC Content - Condition: 120°C*5h	< 18.0	µgC/g	VDA 277
Fogging - Condition: 100°C*18h	< 2.0	mg	DIN 75201
Ethylbenzene Emissions - Condition: 120°C*5h	< 8.00	µg/g	VDA 277
Odor			VDA 270
Condition: 23°C*24h	Grade 2		
Condition: 40°C*24h	Grade 3		
Condition: 80°C*2h	Grade 3		
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	108		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	42.0	MPa	ISO 527-2/50
Tensile Strain (Break)	20	%	ISO 527-2/50
Flexural Modulus ¹	2200	MPa	ISO 178
Flexural Stress ²	60.0	MPa	ISO 178
Poisson's Ratio ³	0.39		ISO 527
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁴			ISO 180

-30°C	8.0	kJ/m ²	
23°C	15	kJ/m ²	
Unnotched Izod Impact Strength ⁵ (23°C)	No Break		ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶			
0.45 MPa, Unannealed	98.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	90.0	°C	ISO 75-2/A
Vicat Softening Temperature	107	°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
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 95.0	°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	240 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.	1 mm/min		
4.	Condition: 5.5 J		
5.	Condition: 5.5 J		
6.	120°C/h		

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