

KumhoSunny PC/ABS HAC8240B

Polycarbonate + ABS

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HAC8240B is a blow molding grade PC/ABS resin. PC/ABSHAC8240B has been widely used in Auto exterior parts, such as Spoiler and so on.

General Information			
Features	High Impact Resistance		
Uses	Automotive Applications		
	Automotive Exterior Parts		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Blow Molding		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.10	g/cm ³	ASTM D792
--	1.11	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/10.0 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage			
Flow	0.50 to 0.70	%	ASTM D955
--	0.50 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	45.0	MPa	ASTM D638
--	52.0	MPa	ISO 527-2/50
Tensile Elongation (Break)	80	%	ASTM D638
Flexural Modulus			
--	2000	MPa	ASTM D790
-- ¹	2200	MPa	ISO 178
Flexural Strength			
--	65.0	MPa	ASTM D790
-- ²	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179

-30°C	36	kJ/m²	
23°C	55	kJ/m²	
Charpy Unnotched Impact Strength ⁴ (23°C)	No Break		ISO 179
Notched Izod Impact			
3.20 mm	650	J/m	ASTM D256
23°C ⁵	52	kJ/m²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	98.0	°C	ASTM D648
1.8 MPa, Unannealed ⁶	95.0	°C	ISO 75-2/A
Vicat Softening Temperature	110	°C	ISO 306/B50, ASTM D1525 ⁷
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	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	220 to 240	°C	
Middle Temperature	230 to 250	°C	
Front Temperature	240 to 260	°C	
Nozzle Temperature	240 to 260	°C	
Processing (Melt) Temp	240 to 260	°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.	4J		
4.	4J		
5.	5.5J		
6.	120°C/h		
7.	Rate B (120°C/h)		

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